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(54) **NOVEL RESIN-CURING PROCESS ENABLING THE ACTINIC RADIATION CURE OF RESINS CONTAINING SHIELDINGS AGAINST ACTINIC RADIATIONS; COMPOSITION FOR THE PROCESS, MOLDINGS, AND MOLDING PROCESS**

(57) An object of the present invention is to completely cure a resin composition highly capable of screening energy radiation, such as a carbon fiber-reinforced composite material (CFRP), simply by exposing the resin composition to UV radiation in the presence of a specific photopolymerization initiator system (reaction catalyst system) comprising at least two components. To this end, the present invention provides a resin curing method wherein, when a resin composition is exposed to energy radiation typified by UV radiation, another kind of first energy than the energy from an energy radiation source is autogenously generated within the resin, and the same kind of second energy is successively generated by the autogenously generated energy, so that the resin composition is cured by means of the first and second energies, or both the first and second energies and the energy from the energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation.

5 benzyl sulf
7 epoxycyclohex
no enhy

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Description

TECHNICAL FIELD

5 [0001] The present invention relates to a resin curing method for curing resins rapidly by means of energy radiation such as ultraviolet radiation (UV), electron beam (EB), infrared radiation, X-rays, visible light, light from lasers (e.g., argon, CO₂ and excimer lasers), sunlight and radiated heat rays, and other energy such as heat, and to polymerization initiators and compositions which enable resins to be cured by this method, molded articles made therefrom, and their production methods and apparatus.

10 [0002] More particularly, the present invention relates to a resin curing method for thick-walled resins in which energy radiation is attenuated or absorbed by the resin to cause a marked reduction in curing action and, therefore, the deep part thereof cannot be cured, and for resins reinforced with fillers (e.g., carbon fiber, metallic fibers and glass fiber) or metallic inserts in which energy radiation is screened by such reinforcing materials and, therefore, the shaded part of the resin cannot be completely cured, and to polymerization initiators and compositions which enable such resins to be
15 cured by this method, molded articles made therefrom, and their production methods and apparatus.

[0003] The present invention also relates to a novel resin curing method which enables the energy radiation curing of resin systems containing substances highly capable of screening energy radiation (e.g., carbon, carbon fiber (CF), metals and other inorganic fillers), such as carbon fiber-reinforced composite materials (CFRPs) and carbon/metal/inorganic matter-containing resins, and to compositions therefor, molded articles made therefrom, and their production
20 methods.

[0004] The present invention also relates to a method of making a fiber-reinforced composite material (FRP) wherein a composition capable of inducing the novel resin curing mechanism in the aforesaid resin curing method is used as the matrix resin, and a reinforcing fiber (e.g., CF) is impregnated with this resin and then cured by means of energy radiation typified by UV.

25 [0005] The aforesaid curing method, compositions, molded articles and molding methods are effective without regard to the UV screening properties of fibers or fillers, and the length, size and shape thereof. Moreover, they can be utilized not only in the field of composite materials, but also in the fields of adhesives, sealers, varnishes, paints, coating materials, inks, toners and the like.

30 BACKGROUND ART

[0006] In recent years, energy radiation-curable resins typified by UV-curable resins are being used in various fields and applications. These resins are characterized in that they are cured only in regions exposed to more than a certain amount of energy radiation. On the other hand, energy radiation typified by UV radiation is characterized in that it is
35 attenuated while it passes through a resin. As a result, it is difficult for energy radiation to reach the deep part of a resin, and energy radiation is greatly attenuated or absorbed, for example, in the presence of a substance capable of absorbing a wavelength equal to that of the energy radiation. Thus, photo-curable resins are cured only in a surface layer having a thickness of several micrometers to several millimeters through which energy radiation can pass, and the deep part thereof remain uncured. Consequently, it is difficult or impossible to apply photo-curable resins to thick-walled materials.
40 Moreover, in the case of resins containing fillers and other substances hindering the passage of energy radiation, they tend to undergo inhibition of their cure and hence become incurable. Owing to these problems, their application has been chiefly limited to the fields of photoresists, coatings, paints, adhesives, varnishes and the like.

[0007] Typical solutions to these problems are offered by highly UV-curable resins (Mitsubishi Rayon Co., Ltd.; active energy radiation-curable compositions; Japanese Patent Provisional Publication No. 8-283388/96) and UV- and heat-curable resins (Optomer KS series (Asahi Denka Kogyo K.K.); Radicure (Hitachi Chemical Co., Ltd.); UE resin (Toyobo Co., Ltd.); Japanese Patent Publication (JP-A) No. 6-38023/86; and the like). However, highly UV-curable resins still have the problem that they cannot be cured when energy radiation is blocked by a filler or the like. Moreover, in UV- and heat-curable resins which are cured by heating after exposure to UV radiation, their energy radiation curability is similar to that of conventional photo-curable resins, and the problems associated with the curing of thick-walled resins
50 and filler-containing resins remain entirely unsolved. Thus, under the existing circumstances, these problems cannot be solved and are hence coped with by heat curing subsequent to photo-curing (of a surface layer alone).

[0008] If a technique by which the above-described thick-walled resins containing an energy radiation screening substance or highly capable of attenuating or absorbing energy radiation can be cured rapidly is established, this technique may be applied not only to conventional fields of application, but also to various other fields in which the application of
55 energy radiation curing has been impossible owing to the problems of photo-curable resins. One example thereof is application to the matrix resins of FRPs, particularly CFRPs.

[0009] Conventionally, a variety of processing techniques and production processes are employed for FRPs, but the matrix resin consists of a thermosetting or thermoplastic resin in most cases. The problems associated with the molding

of FRPs, particularly CFRPs, are that high processing costs are involved because a long curing time results from complicated temperature control, a large-sized heating oven is required for the curing of large-sized FRPs, resins capable of being cured at room temperature in a short period of time cannot be used for large-sized FRPs requiring a long curing time, the molding of FRPs is difficult because the resin-impregnated state varies according to changes in resin viscosity with temperature, and the formation of voids arises from residual solvent during the curing of the resin and causes a reduction in the quality of the molded article.

[0010] Recently, as a solution to these problems, the utilization of a photo-curable resin as the matrix resin is attracting attention. A particular and typical example of this matrix resin curing method is the filament winding molding process of Loctite Corp. which uses a combination of UV curing and heat curing (Loctite Corp.; Fiber/resin composition and its preparation method; Published Japanese Translation of PCT International Publication No. 7-507836/95). However, in the FRP molding process using such a composition, an uncured resin-impregnated FRP is irradiated with UV radiation so as to cure its surface and so as to thicken (or gelatinize) its inner part extremely and thereby enable the maintenance of its shape and resin-impregnated state to some extent, and then heated to achieve a complete cure. Accordingly, as compared with the conventional production process using a thermoplastic or thermosetting resin, the change in resin viscosity with temperature is very slight and the handling of the FRP after resin impregnation is easy, but a heat curing step is still required in order to achieve a complete cure. Thus, the problem of high processing costs arising from the fuel and light expenses and operating time required for heat curing, the problem of a long curing time, and the need for a large-sized heating oven in the molding of large-sized FRPs remain unsolved.

DISCLOSURE OF THE INVENTION

[0011] In view of the above-described disadvantages of conventional resins cured by energy radiation and the above-described disadvantages of FRPs, particularly CFRPs, the present inventors made intensive investigations on the energy radiation curing of thick-walled resins containing an energy radiation screening substance (i.e., a substance capable of screening energy radiation) and the energy radiation curing of FRPs, particularly CFRPs, and have now attained the present invention. An object of the present invention is to provide a novel resin curing method which enables the energy radiation curing of resin systems containing substances highly capable of screening energy radiation (e.g., carbon, carbon fiber (CF), metals and other inorganic fillers), such as carbon fiber-reinforced composite materials (CFRPs) and carbon/metal/inorganic matter-containing resins, as well as compositions therefor, molded articles made therefrom, and molding methods thereof.

[0012] Another object of the present invention is to incorporate a specific photopolymerization initiator (reaction catalyst system) comprising at least two components (i.e., a system comprising two or more components) into a resin composition highly capable of screening energy radiation, such as a carbon fiber-reinforced composite material (CFRP), whereby even the shaded part or deep part of the resin composition can be completely cured solely by exposure to energy radiation such as UV or EB.

[0013] The above objects can be effectively accomplished by various inventions summarized below.

(1) A resin curing method wherein, when energy is applied to a resin composition, another kind of energy than the energy from an external energy source is autogenously generated within the resin, so that the resin composition is cured by means of the autogenously generated energy, or both the autogenously generated energy and the energy from the external energy source.

(2) A resin curing method wherein, when energy is applied to a resin composition, another kind of first energy than the energy from an external energy source is autogenously generated within the resin, and the same kind of second energy is successively generated by the autogenously generated energy, so that the resin composition is cured by means of the first and second energies, or both the first and second energies and the energy from the external energy source.

(3) A resin curing method wherein, when a resin composition is exposed to energy radiation, another kind of energy than the energy from an external energy radiation source is autogenously generated within the resin, so that the resin composition is cured by means of the autogenously generated energy, or both the autogenously generated energy and the energy from the external energy radiation source.

(4) A resin curing method wherein, when a resin composition is exposed to energy radiation, another kind of first energy than the energy from an external energy radiation source is autogenously generated within the resin, and the same kind of second energy is successively generated by the autogenously generated energy, so that the resin composition is cured by means of the first and second energies, or both the first and second energies and the energy from the external energy radiation source.

(5) A resin curing method wherein heat energy is autogenously generated within the resin as the generated energy described above in (3), so that the resin composition is cured by means of the heat energy, or both the heat energy and the energy from the external energy radiation source, whether or not the resin composition contains a sub-

stance capable of screening energy radiation (hereinafter referred to as "an energy radiation screening substance").

(6) A resin curing method wherein a first heat energy is autogenously generated within the resin as the generated energy described above in (4), and a second heat energy is successively generated by the generated first heat energy, so that the resin composition is cured by means of the first and second heat energies, or both the first and second heat energies and the energy from the external energy radiation source, whether or not the resin composition contains an energy radiation screening substance.

(7) A resin curing method wherein the heat of curing reaction evolved during the cure of the resin composition by exposure to external energy radiation is positively generated as the heat energy autogenously generated within the resin as described above in (5), so that the resin composition is cured by means of the reaction heat energy, or both the reaction heat energy and the energy from the external energy radiation source, whether or not the resin composition contains an energy radiation screening substance.

(8) A resin curing method wherein the heat of curing reaction evolved during the cure of the resin composition by exposure to energy radiation is positively generated as the first heat energy autogenously generated within the resin as described above in (6), and the curing reaction is further effected, like a chain reaction, by the action of the heat of curing reaction to generate additional heat of curing reaction as the successively generated second heat energy, so that the resin composition is cured by means of the first and second reaction heat energies, or both the first and second reaction heat energies and the energy from the energy radiation source, whether or not the resin composition contains an energy radiation screening substance.

(9) A resin curing method wherein, in the curing reaction described above in any of (1) to (8), at least one species selected from the group consisting of a cation, a radical and an anion is utilized to induce curing or facilitate the curing reaction by the action of the energy from the external energy source, the energy radiation from the energy radiation source, or the heat of reaction.

(10) A resin curing method as described above in (9) wherein, when the resin composition is exposed to energy radiation, a cation and a first heat of curing reaction evolved during the cure of the resin composition by the action of the energy radiation are positively generated within the resin, and the curing reaction is further effected, like a chain reaction, by the action of the cation and the first heat of curing reaction to successively generate an additional cation and a second heat of curing reaction, so that the resin composition is cured by means of the first and second reaction heat energies and the cation, or the combination of the first and second reaction heat energies, the cation, and the energy from the energy radiation source, whether or not the resin composition contains an energy radiation screening substance.

(11) A resin curing method as described above in any of (1) to (10) wherein the cure of the resin composition is facilitated by warming it previously in a temperature range which does not cause its cure.

(12) A resin curing method as described above in any of (1) to (11) wherein a polymerization initiator is used.

(13) A resin curing method as described above in any of (1) to (12) wherein the cure of the composition is initiated by means of heat or the composition is cured by means of heat.

(14) A photopolymerization initiator comprising at least two components including a photopolymerization initiator and a photo- and thermopolymerization initiator for initiating polymerization by means of both light and heat, and serving as the polymerization initiator making it possible to carry out a resin curing method as described above in (13).

(15) A photopolymerization initiator comprising at least two components as described above in (14) wherein a photo- and thermopolymerization initiator having a powerful polymerization-initiating effect upon exposure to heat is used as the photo- and thermopolymerization initiator.

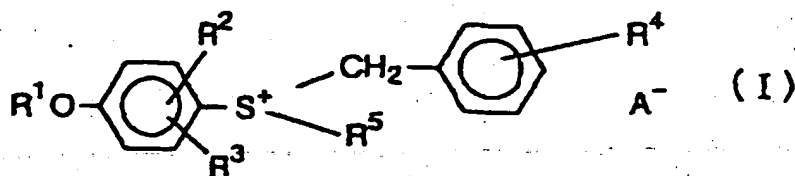
(16) A photopolymerization initiator comprising at least two components which includes at least one photopolymerization initiator comprising at least two components as described above in (14) or (15), and a thermopolymerization initiator.

(17) A photopolymerization initiator comprising at least two components as described above in any of (14) to (16) which consists essentially or entirely of radical polymerization initiators.

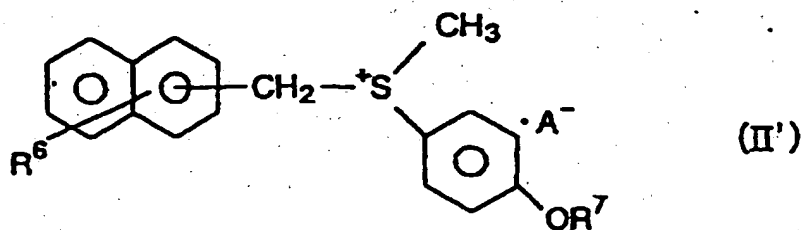
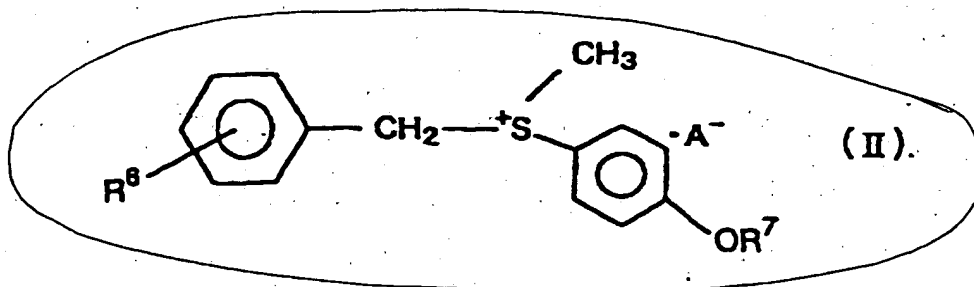
(18) A photopolymerization initiator comprising at least two components as described above in any of (14) to (16) which consists essentially or entirely of anionic polymerization initiators.

(19) A photopolymerization initiator comprising at least two components as described above in any of (14) to (16) which consists essentially or entirely of cationic polymerization initiators.

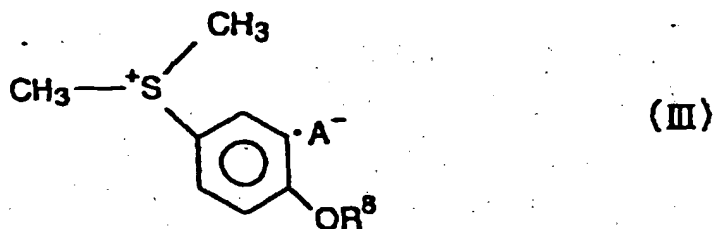
(20) A photopolymerization initiator comprising at least two components as described above in (19) wherein the photopolymerization initiator comprises at least one compound selected from diazonium salt type compounds, iodonium salt type compounds, pyridinium salt type compounds, phosphonium salt type compounds, sulfonium salt type compounds, iron-arene complex type compounds, and sulfonate type compounds, and the photo- and thermopolymerization initiator comprises at least one of the sulfonium salts represented by the following general formulae (I), (II), (III), (IV), (V), (VI) and (VII).



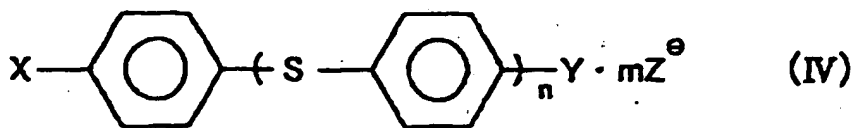
where R^1 represents hydrogen, methyl, acetyl or methoxycarbonyl, R^2 and R^3 each independently represents hydrogen, halogen or an alkyl group of 1 to 4 carbon atoms, R^4 represents hydrogen, halogen or methoxy, R^5 represents an alkyl group of 1 to 4 carbon atoms, and A represents SbF_6 , PF_6 , AsF_6 or BF_4 .



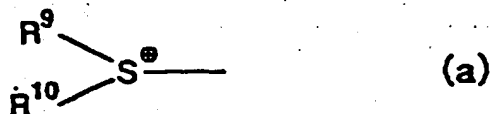
where R^6 represents a hydrogen atom, a halogen atom, a nitro group or a methyl group, R^7 represents a hydrogen atom, CH_3CO or CH_3OCO , and A represents SbF_6 , PF_6 , BF_6 or AsF_6 .



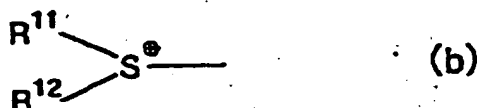
where R^8 represents a hydrogen atom, CH_3CO or CH_3OCO , and A represents SbF_6 , PF_6 , BF_6 , AsF_6 or CH_3SO_4 .



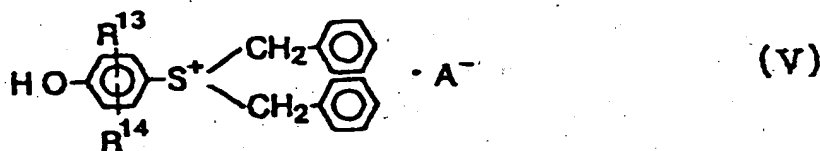
where X represents a sulfonio group of the general formula



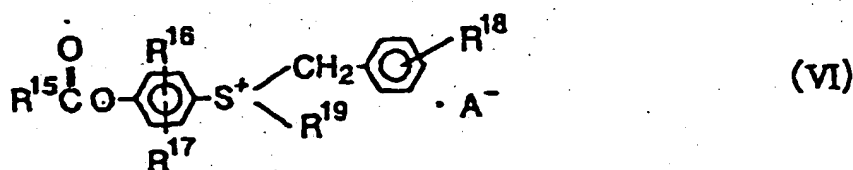
in which R^9 represents an aliphatic group of 1 to 18 carbon atoms, R^{10} represents an aliphatic group of 1 to 18 carbon atoms or a substituted or unsubstituted aromatic group of 6 to 18 carbon atoms, and R^9 and R^{10} may be joined together to form a ring; Y represents a sulfonio group of the general formula



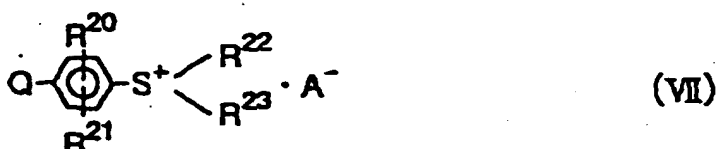
in which R^{11} represents an aliphatic group of 1 to 18 carbon atoms, R^{12} represents an aliphatic group of 1 to 18 carbon atoms or a substituted or unsubstituted aromatic group of 6 to 18 carbon atoms, and R^{11} and R^{12} may be joined together to form a ring, or Y represents a hydrogen atom, a halogen atom, a nitro group, an alkoxy group, an aliphatic group of 1 to 18 carbon atoms, or a substituted or unsubstituted phenyl, phenoxy or thiophenoxy group of 6 to 18 carbon atoms; n and m are each independently 1 or 2; and Z is an anion represented by the formula MQ_l or MQ_{l-1}OH in which M is B, P, As or Sb, Q is a halogen atom, and l is 4 or 6.



where R^{13} and R^{14} independently represent hydrogen or alkyl groups of 1 to 4 carbon atoms, and A represents SbF_6 , PF_6 or AsF_6 .



where R^{15} represents ethoxy, phenyl, phenoxy, benzyloxy, chloromethyl, dichloromethyl, trichloromethyl or trifluoromethyl, R^{16} and R^{17} each independently represents hydrogen, halogen or an alkyl group of 1 to 4 carbon atoms, R^{18} represents hydrogen, methyl, methoxy or halogen, R^{19} represents hydrogen, methyl, methoxy or halogen, R^{19} represents an alkyl group of 1 to 4 carbon atoms, and A represents SbF_6 , PF_6 , BF_4 or AsF_6 .

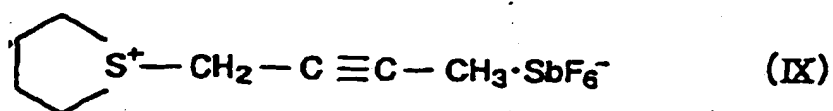
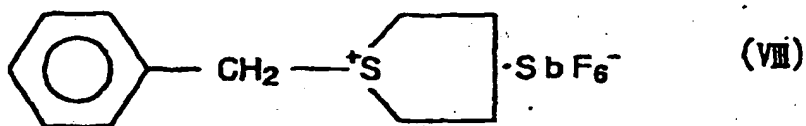


where Q represents methoxycarbonyloxy, acetoxy, benzyloxycarbonyloxy or dimethylamino, R^{20} and R^{21} each

independently represents hydrogen or an alkyl group of 1 to 4 carbon atoms, R^{22} and R^{23} each independently represents an alkyl group of 1 to 4 carbon atoms, and A represents SbF_6 , PF_6 , AsF_6 or BF_4 .

(21) A photopolymerization initiator comprising at least two components as described above in (20) wherein the photopolymerization initiator comprises an arylsulfonium salt type compound, and the photo- and thermopolymerization initiator comprises at least one sulfonium salt represented by the general formula (I), (II) or (III).

(22) A photopolymerization initiator comprising at least two components which includes at least one of the photopolymerization initiator comprising at least two components as described above in any of (19) to (21), and a thermopolymerization initiator comprising at least one of the compounds represented by the following chemical formulae (VIII) and (IX).



(23) A composition making it possible of carry out a curing method as described above in any of (1) to (13) wherein, when the composition is exposed to energy radiation, another kind of energy than the energy from the energy radiation source is autogenously generated within the composition, or wherein, when the composition is exposed to the energy radiation, another kind of first energy than the energy from the energy radiation source is autogenously generated within the composition, and the same kind of second energy is successively generated by the generated first energy.

(24) A composition as described above in (23) which contains a photopolymerization initiator and a photopolymerizable oligomer or photopolymerizable monomer.

(25) A composition as described above in (23) or (24) which contains, as an essential ingredient, a photopolymerization initiator comprising at least two components as described above in any of (14) to (22).

(26) A resin composition as described above in (25) which comprises, as essential ingredients, any of the photopolymerization initiators comprising at least two components as described above in any of (19) to (22), and a cationic photopolymerizable oligomer or cationic photopolymerizable monomer.

(27) A resin composition as described above in (26) wherein a photopolymerizable epoxy oligomer or photopolymerizable epoxy monomer is used as the cationic photopolymerizable oligomer or cationic photopolymerizable monomer.

(28) A resin composition as described above in (27) wherein a photopolymerizable alicyclic epoxy oligomer or photopolymerizable alicyclic epoxy monomer is used as the photopolymerizable epoxy oligomer or photopolymerizable epoxy monomer.

(29) A resin composition as described above in (28) wherein 3,4-epoxycyclohexylmethyl 3,4-epoxycyclohexanecarboxylate is used as the photopolymerizable alicyclic epoxy monomer.

(30) A resin composition as described above in any of (25) to (29) wherein the photopolymerization initiator comprising at least two components is contained in an amount of 0.5 to 6.0 parts by weight per 100 parts by weight of the photopolymerizable resin component (photopolymerizable oligomer or monomer), and the weight ratio of the photo- and thermopolymerization initiator to the photopolymerization initiator constituting the photopolymerization initiator comprising at least two components is in the range of 1 to 4.

(31) A resin composition as described above in (30) which comprises a photopolymerization initiator comprising at least two components as described above in any of (20) to (22), and a photopolymerizable resin component as described above in any of (26) to (29).

(32) A composition as described above in any of (23) to (31) which contains at least one additive selected from energy radiation screening substances, various fillers and organic components.

(33) A composition as described above in any of (23) to (32) which additionally contains at least one additive selected from photosensitizers, reactive diluents and photosensitive compounds.

(34) A cured product obtained by a method as described above in any of (1) to (13).

(35) A molded article made from a composition containing a photopolymerization initiator comprising at least two

components as described above in any of (4) to (22).

(36) A molded article made from a composition as described above in any of (23) to (33).

(37) A molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material, other composite material, adhesive, sealer, varnish, paint or coating material, ink or toner which contains a composition making it possible to carry out a resin curing method as described above in any of (1) to (13).

(38) A molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material, other composite material, adhesive, sealer, varnish, paint or coating material, ink or toner which contains a photopolymerization initiator comprising at least two components as described above in any of (14) to (22).

(39) A molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material, other composite material, adhesive, sealer, varnish, paint or coating material, ink or toner which contains a composition as described above in any of (23) to (33).

(40) A method of making a molded article of a molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material or other composite material, a cured product of an adhesive, sealer, varnish, paint or coating material, or matter printed with ink or toner, by utilizing a resin curing method as described above in any of (1) to (13).

(41) A method of making a molded article of a molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material or other composite material, a cured product of an adhesive, sealer, varnish, paint or coating material, or matter printed with ink or toner, by utilizing a resin composition making it possible to carry out a curing method as described above in any of (1) to (13).

(42) A method of making a molded article of a molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material or other composite material, a cured product of an adhesive, sealer, varnish, paint or coating material, or matter printed with ink or toner, by utilizing a composition containing a photopolymerization initiator comprising at least two components as described above in any of (14) to (22).

(43) A method of making a molded article of a molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material or other composite material, a cured product of an adhesive, sealer, varnish, paint or coating material, or matter printed with ink or toner, by utilizing a resin composition as described above in any of (23) to (33).

(44) A method of making a fiber-reinforced composite material or carbon fiber-reinforced composite material as described above in any of (40) to (43) wherein the fiber-reinforced composite material or carbon fiber-reinforced composite material is made by utilizing at least one technique selected from hand lay-up, spray-up, filament winding, tape winding, roll winding, draw molding and continuous roll pressing.

(45) A method of making a prepreg which comprises impregnating a reinforcing fiber or a reinforcing fiber cloth material with a resin composition as described above in any of (23) to (33).

(46) A method of making a fiber-reinforced composite material which comprises stacking prepregs made by the method described above in (45), and curing them according to a curing method as described above in any of (1) to (13).

(47) A method of making a fiber-reinforced composite material which comprises impregnating a three-dimensional textile with a composition as described above in any of (23) to (33), and curing it according to a curing method as described above in any of (1) to (13).

(48) A method of repairing a fiber-reinforced composite material, building, structure or product which comprises filling a part to be repaired of a fiber-reinforced composite material, building, structure or product with a composition as described above in any of (23) to (33), or attaching a prepreg made by the method described above in (45) to a part to be repaired of a fiber-reinforced composite material, building, structure or product; and curing the composition or prepreg according to a curing method as described above in any of (1) to (13).

(49) A method of reinforcing a fiber-reinforced composite material, building, structure or product which comprises attaching a prepreg made by the method described above in (45) to a part to be reinforced of a fiber-reinforced composite material, building, structure or product, and curing the prepreg according to a curing method as described above in any of (1) to (13), or which comprises using a composition as described above in any of (23) to (33), attaching a reinforcing fiber or reinforcing fiber cloth material to a part to be reinforced of a fiber-reinforced composite material, building, structure or product by spray-up or brushing, and curing the composition according to a curing method as described above in any of (1) to (13).

(50) A method as described above in any of (40) to (49) wherein carbon fiber is used as the fibrous material.

(51) A method as described above in any of (40) to (50) wherein there is used a material in which the composition contains a photopolymerization initiator comprising at least two components as described above in any of (20) to (22).

(52) A method as described above in any of (40) to (50) wherein there is used a material comprising a composition as described above in (30).

(53) A method as described above in any of (40) to (50) wherein there is used a composition as described above

in (31).

(54) A molded article made by a method as described above in any of (40) to (43).

(55) A fiber-reinforced composite material or carbon fiber-reinforced composite material as described above in any of (37) to (39).

(56) A molded article made by the method described above in (44).

(57) A prepreg made by the method described above in (45).

(58) A fiber-reinforced composite material obtained by curing a prepreg as described above in (57).

(59) A fiber-reinforced composite material obtained by impregnating a three-dimensional textile with a composition as described above in any of (23) to (33), and curing the resin composition.

(60) A repair material for filling a part to be repaired of a fiber-reinforced composite material, building, structure or product which comprises a composition as described above in any of (23) to (33).

(61) A reinforcing material for a fiber-reinforced composite material, building, structure or product which comprises a composition as described above in any of (23) to (33).

(62) A material or molded article as described above in any of (37) to (39) or any of (54) to (61) wherein carbon fiber is used as the fibrous material.

(63) A material or molded article as described above in any of (37) to (39) or any of (54) to (62) wherein the composition contains a photopolymerization initiator comprising at least two components as described above in any of (20) to (22).

(64) A material or molded article as described above in any of (37) to (39) or any of (54) to (62) which comprises a composition as described above in (30).

(65) A material or molded article as described above in any of (36) to (38) or any of (54) to (62) which comprises a composition as described above in (30).

[0014] In the above-described methods of the present invention, particularly in the methods described in (1) to (13), the resin composition can be cured by causing energy (e.g., heat energy) to be autogenously generated within the resin and, in some cases, causing energy to be successively generated by the generated energy. Specifically, the above-described methods can be carried out by using, as the polymerization reaction catalyst, a photopolymerization initiator system (reaction catalyst system) comprising at least two components including a photopolymerization initiator and a photo- and thermopolymerization initiator.

[0015] That is, to sum up more briefly, the present invention is characterized by a novel resin curing mechanism enabling the energy radiation curing of CFRPs and thick-walled resins containing an energy radiation screening substance, photopolymerization initiator systems (reaction catalyst systems) comprising at least two components and capable of inducing this curing mechanism, and compositions containing them. It is preferable to use a photopolymerization initiator system (reaction catalyst system) comprising at least two components in which the photopolymerization initiator comprises at least one compound selected from diazonium salt type compounds, iodonium salt type compounds, pyridinium salt type compounds, phosphonium salt type compounds, sulfonium salt type compounds, iron-arene complex type compounds and sulfonate type compounds, and the photo- and thermopolymerization initiator comprises at least one of the sulfonium salts represented by the general formulae (I) to (VII). It is more preferable to use a photopolymerization initiator system (reaction catalyst system) comprising at least two components in which the photopolymerization initiator comprises an arylsulfonium type compound (i.e., a triarylsulfonium type compound) and the photo- and thermopolymerization initiator comprises at least one of the sulfonium salts represented by the general formulae (I), (II) and (III).

[0016] Moreover, thermopolymerization initiators, typified by those of chemical formulae (VIII) and (IX), may be added to the aforesaid photopolymerization initiator systems comprising at least two components. Furthermore, the present invention also relates to the compositional range of specific photopolymerization initiator systems comprising at least two components; resin compositions capable of inducing the novel resin curing mechanism, the formulations thereof, and molded articles made therefrom; a method for utilizing the aforesaid curing mechanism and resin compositions; and a method of making FRPs using such a resin as the matrix resin, resin compositions therefor, and molded articles made therefrom.

BRIEF DESCRIPTION OF DRAWINGS

[0017]

FIG. 1 is a schematic view illustrating the manner in which UV energy is attenuated while it passes through a resin composition;

FIG. 2 is a schematic view illustrating the manner in which UV energy is attenuated while it passes through a resin composition containing a carbon cloth material;

FIG. 3 includes schematic views illustrating the UV-cured state of the respective resin compositions shown in FIGs. 1 and 2;

FIG. 4 includes schematic views for explaining the resin curing mechanism of the present invention (i.e., a curing system utilizing light plus heat of curing reaction and cation);

FIG. 5 is an explanatory view of a curing model for highly UV-curable resins;

FIG. 6 is an explanatory view of a curing model for UV- and heat-curable resins known in the prior art;

FIG. 7 is a flow diagram of an exemplary FRP molding process, illustrating ① a lay-up process;

FIG. 8 is a flow diagram of exemplary FRP molding processes, illustrating ② a drawing process, ③ a filament/tape/roll winding process, and ④ a continuous roll pressing process;

FIG. 9 is a graph showing a proper compositional range for a photopolymerization initiator system in accordance with the present invention;

FIG. 10 is a graph showing the relationship between the time elapsed and the resin temperature after UV irradiation for 60 seconds in the practice of the present invention;

FIG. 11 is a graph showing the relationship between the UV irradiation distance and the resin temperature after UV irradiation for 60 seconds in the practice of the present invention; and

FIG. 12 is an explanatory view illustrating the manner in which a prepreg laminate sample is made in accordance with the present invention.

BEST MODE FOR CARRYING OUT THE INVENTION

[0018] First of all, the present inventors have paid attention to the fact that resins containing an energy radiation screening substance and thick-walled resins, and their applications such as FRPs and CFRPs, cannot be cured with energy radiation because ① energy typified by UV energy is attenuated while it passes through a substance (resin) (FIG. 1), ② it is easily blocked by a substance capable of absorbing the same wavelength (FIG. 2), and ③ energy radiation-curable resins typified by UV-curable resins are cured only in regions through which more than a certain amount of energy radiation has passed (FIG. 3). With consideration for the fact that the features ① and ② are based on fundamental principles and hence hard to modify, the present inventors made intensive investigations on the securement of energy required for curing purposes, the prevention of energy required for curing purposes from being blocked, and a novel resin curing mechanism enabling the cure of regions not exposed to energy radiation. As a result, the present inventors have revealed a novel resin curing mechanism in which, when a resin composition is exposed to energy radiation or energy is applied to a resin composition, another kind of energy is autogenously generated within the resin, so that the resin composition is cured by means of this energy, or both this energy and the energy from the energy radiation source or energy source, and have developed a resin curing method based on this mechanism.

[0019] In FIG. 1, the manner in which the intensity of UV energy is gradually attenuated while energy radiation from a UV lamp passes through a resin composition is indicated by light and shade in an arrow (i.e., a wavy pattern in this figure). In FIG. 2, UV energy is easily blocked owing to the presence of an energy radiation screening substance such as a carbon cloth material. FIGs. 3(a) and 3(b) each illustrate the manner in which, when a liquid resin is exposed to UV energy, the resin is cured only in regions through which more than a certain amount of energy radiation has passed (as indicated by rightward inclined parallel lines in this figure). (b) indicates the case in which an energy radiation screening substance such as a carbon cloth material is present, so that the cure of the resin is interrupted by the screening substance.

[0020] Besides ultraviolet radiation, useful types of energy radiation include electron rays, X-rays, infrared radiation, sunlight, visible light, laser light (from excimer, O₂ and other lasers), radiated heat rays and other energy. Moreover, the applied energy may comprise not only light or electromagnetic radiation, but also heat or the like.

[0021] As a result of further intensive investigations based on this concept, the present inventors have discovered the successive production of autogenously generated energy, the use of heat energy as the autogenously generated energy, the successive production of heat energy, the use of heat of curing reaction (curing exotherm) as the heat energy, the utilization of a cation, radical or anion, the enhancement of curability by preheating, the utilization of a polymerization initiator, and the like, and have developed a novel resin curing mechanism in which, when a resin composition is exposed to energy radiation, a cation and heat of curing reaction (curing exotherm) are positively generated within the resin, and the resin is further cured, like a chain reaction, by the action of the cation and the heat of curing reaction to successively generate additional cation and heat of curing reaction (curing exotherm), so that the resin composition is cured by means of the reaction heat energy, or both reaction heat energy and the energy from the energy radiation source, whether or not the resin composition contains an energy radiation screening substance (FIG. 4), as well as a resin curing method based on it.

[0022] FIGs. 4(a) and 4(b) are schematic views for explaining the resin curing mechanism of the present invention (i.e., a curing system utilizing light plus heat of curing reaction and cation), and illustrate the manner in which, when a resin composition is exposed to energy radiation, a cation and heat of curing reaction are positively generated within

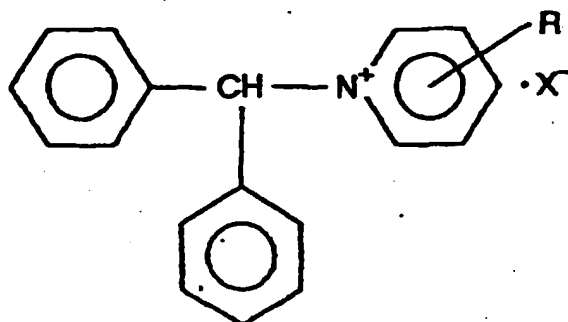
the resin, and the resin is further cured, like a chain reaction, by the action of the cation and the heat of curing reaction. (a) indicates an initial stage and (b) indicates a stage in which the reaction heat cure of the resin composition has progressed to the lowermost layer thereof. In either case, the curing reaction proceeds whether or not the resin composition contains a carbon cloth material. Although a combination of a cation and heat of curing reaction is utilized for purposes of polymerization in this embodiment, it is a matter of common knowledge that a radical or an anion may also be utilized in the present invention as a species participating in the polymerization of the resin. Furthermore, the curing mechanism of the present invention enables resins to be cured by means of not only light or electromagnetic radiation, but also heat or other energy.

[0023] This novel resin curing mechanism, which has now been developed, is quite different from the resin curing mechanisms of highly UV-curable resins and combined UV- and heat-curable resins that are typical of the prior art (FIGs. 5 and 6). Owing to this difference, the novel resin curing mechanism of the present invention does not suffer from the disadvantages of the prior art, such as the poor curability of filler-containing resins and the need for heating after exposure to energy radiation. FIGs. 5(a) and 5(b) each illustrate the resin curing mechanism of a conventional highly UV-curable resin. As shown in (a), this is advantageous in that a thick cured film can be obtained when no energy radiation screening substance is present. However, when such a screening substance is present, the curing reaction does not proceed as shown in (b).

[0024] FIG. 6(a) illustrates the resin curing mechanism of a conventional combined UV- and heat-curable resin. When this resin is exposed to UV energy as shown in (b), its cure does not proceed owing to the presence of an energy radiation screening substance (see the lower picture). Accordingly, in order to cause its cure to proceed, the resin must be heated after exposure to energy radiation as shown in (a). Where an energy radiation screening substance such as a carbon cloth material is present, the problems of conventional UV curing cannot be solved without heating. In both (a) and (b), the upper picture indicates the case in which such a screening substance is not present, and the lower picture indicates the case in which such a screening substance is present.

[0025] Next, as a result of intensive investigations on polymerization initiators capable of inducing the above-described novel resin curing mechanism and making it possible to carry out the above-described resin curing method, the present inventors have found that a photopolymerization initiator system (reaction catalyst system) comprising at least two components including a photopolymerization initiator and a photo- and thermopolymerization initiator which initiates polymerization upon exposure to both light and heat is useful in accomplishing the objects of the present invention.

[0026] In the present invention, it is preferable to use a photopolymerization initiator comprising at least one compound selected, for example, from diazonium salt type compounds shown in Table A below, iodonium salt type compounds shown in Table B, pyridinium salt type compounds represented by the following general formula,



phosphonium salt type compounds described in Japanese Patent Provisional Publication Nos. 6-157624/94 and 7-82283/95, sulfonium salt type compounds shown in Table C below (see Table 1 which will be given later in Example 1), iron-arene complex type compounds such as initiator ⑨ shown in Table 1, and sulfonate type compounds, in combination with a photo- and thermopolymerization initiator comprising at least one of the compounds represented by the general formulae (I) to (VII).

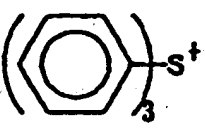
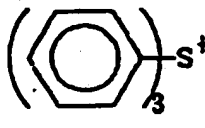
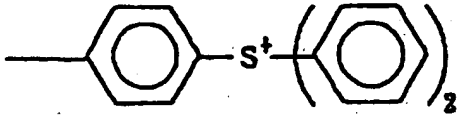
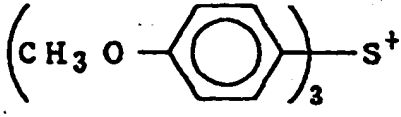
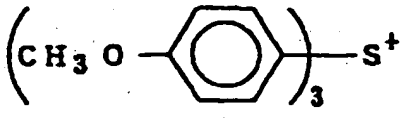
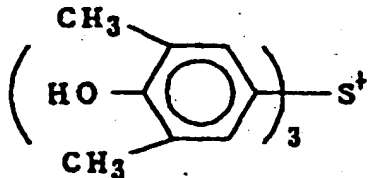
Table A

Aryldiazonium salt photo-initiators		
Cationic moiety (diazonium)	Anionic moiety	Maximum absorption wavelength (nm)
2,5-Diethoxy-4-(p-toluymercapto)benzene	BF_4^-	355, 391
2,4-Dichlorobenzene	SnCl_6^-	285
p-Nitrobenzene	FeCl_4^-	243, 257, 310, 360
p-Chlorobenzene	PF_6^-	273
p-(N-morpholino)benzene	AsF_6^-	257, 378
2,5-Dichlorobenzene	SbF_6^-	238, 358
o-Nitrobenzene	BCl_6^-	285, 313

Tabl B Aromatic iodonium salt photo-initiators

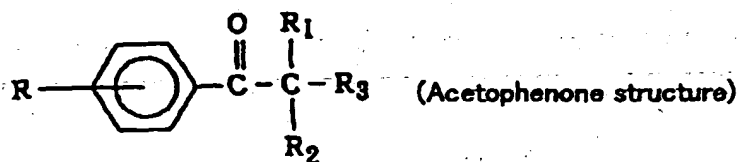
Cationic moiety	Anionic moiety	λ max (nm)	ϵ max
	BF_4^-	227	17,800
	BF_4^-	236	18,000
	BF_4^-	237	18,200
	AsF_6^-	237	17,500
	BF_4^-	238	20,800
	PF_6^-	238	20,000
	AsF_6^-	238	20,700
	SbF_6^-	238	21,200

Tabl. C Triarylsulfonium salt photo-initiators

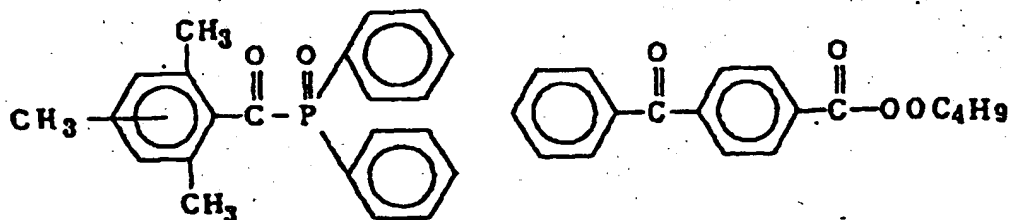
Cationic moiety	Anionic moiety	λ max (nm)	ϵ max
	BF_4^-	230	17,500
	AsF_6^-	230	17,500
	PF_6^-	237, 240	20,400, 19,700
	AsF_6^-	225, 280	21,740, 10,100
	BF_4^-	243, 278	24,700, 4,900
	AsF_6^-	263 280 316	25,200 22,400 7,700

[0027] Moreover, there may also be used radical photopolymerization initiators shown in the following Tables D and E.

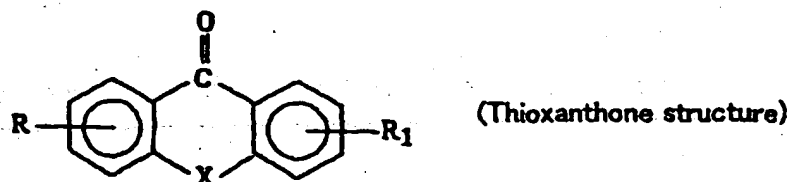
Table D P1 type photo-initiators



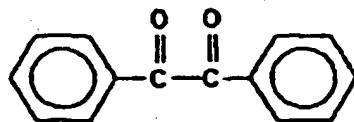
Designation	R	R ₁	R ₂	R ₃
Benzoin butyl ether	H	OC ₄ H ₉	H	C ₆ H ₅
Benzyl dimethyl ketal	H	OCH ₃	OCH ₃	C ₆ H ₅
Ethoxyacetophenone	H	OC ₂ H ₅	OC ₂ H ₅	H
Acyloxime ester	H	NOCO	CH ₃	C ₆ H ₅
	H	NOCO	OC ₂ H ₅	CH ₃
Chlorinated acetophenone	C ₆ H ₄	Cl	Cl	Cl
Hydroxyacetophenone	H	OH	CH ₃	CH ₃



Acylphosphine oxide

Table E P2 type photo-initiators

Designation	X	R	R ₁
Benzophenone	-	R	H
Michler's ketone	-	(CH ₃) ₂ N	(CH ₃) ₂ N
Dibenzosuberone	CH ₂ -CH ₂	H	H
2-Ethylanthraquinone	C=O	H	2-C ₂ H ₅
Isobutylthioxanthone	S	H	2-i-C ₃ H ₇

Benzil

[0028] Specific examples of the compounds represented by the general formulae (I) to (III) include photopolymerization initiators ① to ③ used in the Examples which will be given later ["Journal of Polymer Science", Part A: "Polymer Chemistry", Vol. 29, 1675-1680 (1991); "Kobunshi", Vol. 40, December 1991, 794-797].

[0029] Specific examples of the compounds represented by the general formulae (IV) include bis{4-(dimethylsulfonio)phenyl} sulfide bis-hexafluorophosphate and dimethyl-4-thiophenoxyphenylsulfonium hexafluoroantimonate.

[0030] A specific example of the compounds represented by the general formulae (V) is dibenzyl-4-hydroxyphenylsulfonium hexafluoroantimonate, a specific example of the compounds represented by the general formulae (VI) is benzyl-4-(ethoxycarbonyloxy)phenylmethylsulfonium hexafluoroantimonate, and a specific example of the compounds represented by the general formulae (VII) is 4-acetoxyphenyldimethylsulfonium hexafluoroantimonate.

[0031] Preferred examples of other combinations include photopolymerization initiator systems (reaction catalyst systems) comprising at least two components in which the photopolymerization initiator comprises at least one arylsulfonium salt type compound as shown in Table C (i.e., a triarylsulfonium salt such as photo-initiator ⑥ shown in Table 1) and the photo- and thermopolymerization initiator comprises at least one of the sulfonium salts represented by the above general formulae (I) to (III).

[0032] The present inventors carried the aforesaid investigations further and, as a result, have found that it is preferable to use, as the photo- and thermopolymerization initiator, a photo- and thermopolymerization initiator having a powerful catalytic effect upon exposure to heat, such as the compounds represented by the above general formulae (I) to (III) (i.e., photo-initiators ① to ③ shown in Table 1), and it is preferable to use, as the thermopolymerization initiator, prenyltetramethylenesulfonium hexafluoroantimonate represented by chemical formula (VIII) or 2-butylnyltetramethylenesulfonium hexafluoroantimonate represented by chemical formula (IX).

[0033] Finally, as a result of similar intensive investigations on resin compositions which can induce the aforesaid novel resin curing mechanism and make it possible to carry out the aforesaid resin curing method, the present inventors

have obtained the following findings. Specifically, it has been found that resin compositions comprising a photopolymerization initiator comprising at least two components and a photopolymerizable oligomer or photopolymerizable monomer, and molded articles made therefrom are useful. Among others, it is preferable to use a cationic photopolymerizable oligomer or cationic photopolymerizable monomer and, in particular, a photopolymerizable epoxy oligomer or photopolymerizable epoxy monomer. Examples of such photopolymerizable oligomers include alicyclic epoxies, glycidyl ether type epoxies, epoxidized polyolefins, epoxy (meth)acrylates, polyester acrylates and vinyl ether compounds. Examples of such photopolymerizable monomers include epoxy monomers, acrylic monomers, vinyl ether and cyclic ethers. Among others, photopolymerizable alicyclic epoxy oligomers and photopolymerizable alicyclic epoxy monomers are preferred. A particularly preferred example of such photopolymerizable alicyclic epoxy oligomers is 3,4-epoxycyclohexylmethyl 3,4-epoxycyclohexanecarboxylate.

[0034] Among others, resin compositions comprising a photopolymerization initiator system comprising at least two components in which the photopolymerization initiator comprises at least one arylsulfonium salt type compound as shown in Table C (i.e., a triarylsulfonium salt such as photo-initiator ⑥ shown in Table 1) and the photo- and thermopolymerization initiator comprises at least one of the sulfonium salts represented by the above general formulae (I) to (III), and at least one photopolymerizable epoxy monomer or oligomer such as 3,4-epoxycyclohexylmethyl 3,4-epoxycyclohexanecarboxylate, and molded articles made therefrom, are preferred.

[0035] In the present invention, the preferred formulation of the aforesaid resin compositions is such that the photopolymerization initiator system (reaction catalyst system) comprising at least two components is contained in an amount of 0.5 to 6.0 parts by weight, more preferably 1.5 to 3.5 parts by weight, per 100 parts by weight of the photopolymerizable resin component (photopolymerizable oligomer or monomer), and the weight ratio of the photo- and thermopolymerization initiator to the photopolymerization initiator constituting the photopolymerization initiator system is in the range of 1 to 4, more preferably 1.3 to 2.8. If the amount of the photopolymerization initiator system comprising at least two components is less than 0.5 part by weight, little effect will be produced. Since its amount is too small for the whole resin composition, it will not function properly. Even if its amount is greater than 6.0 parts by weight, its photo-curing function will remain unchanged. If the weight ratio of the photo- and thermopolymerization initiator to the photopolymerization initiator is less than 1, a sufficient amount of heat will not be generated at the initial stage of cure. This will cause the resin to be cured only in the surface thereof, because the curing function constituting a feature of the present invention is not performed properly. If the weight ratio is greater than 4, the resin will show an undue enhancement in curing properties and, in particular, heat generation properties, resulting in foaming of the resin due to its rapid exothermic cure (the related data are shown in Tables 3 and 4 and FIGS. 9 and 10).

[0036] Furthermore, one or more of various commonly used additives, such as energy radiation screening substances (e.g., carbon, carbon fibers (short fiber, long fiber, continuous filament, carbon cloth, etc.), inorganic fillers and metal powders), various fillers, organic components, photosensitizers, reactive diluents and photosensitive compounds, may be added to the aforesaid resin compositions in such proportions as permit the resin compositions to be cured.

[0037] In addition, the present inventors paid attention to the fact that, in the production of FRPs, particularly CFRPs, a (long-time) heat curing step is considered to be responsible for high processing costs, the size of the apparatus or equipment cannot be reduced because a large-sized heating oven is required for the curing of large-sized FRPs, a short-time curable resin cannot be used for large-sized FRPs because the starting time of cure cannot be controlled at will, it is difficult to maintain the resin-impregnated state and mold the FRP because heating in the production process causes changes in resin viscosity, and the formation of voids causing a reduction in quality arises from residual solvent, and made intensive investigations on the development of a method of making FRPs, particularly CFRPs, in which a heating step is not required, the resin is cured in a short period of time, the starting time of resin cure can be controlled at will, and no solvent is needed. As a result, the present inventors have developed a method of making FRPs and CFRPs which comprises using a resin composition of the present invention as the matrix resin, impregnating a fiber with this matrix resin, and curing the FRP or CFRP by exposure to energy radiation typified by UV radiation while utilizing the novel resin curing mechanism and resin curing method of the present invention, and products so made. The term "product" as used herein means articles, other than buildings and structures, which can be artificially made and fall within the scope of the present invention.

[0038] In a filament winding process using a combination of UV curing and heat curing, which is a typical example of conventional molding techniques, UV curing participates only in the cure of the surface of the resin and the thickening of its inner part. After all, the whole resin is cured by the application of heat as usual. In this conventional technique, therefore, various problems associated with the heat curing step (e.g., those with processing costs and operating time) and other problems such as the need for a large-sized heating oven in the molding of large-sized FRPs remain unsolved. In contrast, the method of making FRPs and CFRPs in accordance with the present invention does not involve such problems.

[0039] In the FRPs made according to the present invention, there may be used any of various fibers commonly used as reinforcing fibers for FRPs, such as carbon fiber, glass fiber and organic fibers. Moreover, these fibers may have any desired form such as a unidirectionally aligned material, a woven fabric or a knit fabric. Furthermore, no particular lim-

itation is placed on the combined use of fibers, and there may be used a combination of carbon fiber and glass fiber or of carbon fiber and a hybrid therebetween. Furthermore, in order to mold FRPs, there may employed any of various common FRP-molding techniques including hand lay-up, spray-up, filament winding, tape winding, roll winding, draw molding and continuous roll pressing (FIGs. 7 and 8).

EXAMPLES

[0040] The present invention is further illustrated by the following examples. However, these examples are not to be construed to limit the scope of the invention.

Example 1

[0041]

(A) 100 parts by weight of ERL-4221 (an alicyclic epoxy resin manufactured by Union Carbide Japan K.K.; 3,4-cyclohexylmethyl 3,4-epoxycyclohexanecarboxylate) was mixed with 1.75 parts by weight of San Aid SI-80L [a cationic photo- and thermopolymerization initiator manufactured by Sanshin Chemical Co., Ltd.; general formula (II)], and 0.75 part by weight of DAICAT 11 (a cationic photopolymerization initiator manufactured by Daicel Chemical Industries Ltd.; an arylsulfonium salt).

(B) Then, a glass vessel {40 mm (diameter) x 80 mm (height)} covered with black paper except its upper part was filled with the above resin to the top of the glass vessel.

(C) This resin was irradiated with UV radiation for 60 seconds. The UV irradiation was carried out under the following conditions.

Ultraviolet irradiator: UVL-1500 M2 (manufactured by Ushio Inc.)

Type of lamp: Metal halide lamp.

Intensity of lamp: 120 W/cm.

Length of lamp: 125 mm.

Atmosphere, temperature and pressure: Air, room temperature and atmospheric pressure.

Irradiation distance: 19 cm.

[0042] After UV irradiation, the resin within the glass vessel was completely cured in several minutes. The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass vessel.

Examples 2 to 245 and Comparative Examples 1 to 187

[0043] Tests were carried out under the same conditions as described in Example 1, except that the resin compositions shown in Table 1 were used and tested according to the formulations shown in Tables 2 and 3. The test results thus obtained are shown in Tables 2, 3 and 4 and FIG. 9. The data obtained by measuring the resin temperature due to curing exotherm are shown in FIG. 10.

Table 1 List of resin compositions

Type	Composition No.	Product name or code	Remarks	Manufacturer
Photopolymerizable resin component (photopolymerizable oligomer or photopolymerizable monomer)	Oligomer ①	Celoxide 2021P	3,4-Epoxy cyclohexylmethyl-3,4-epoxycyclohexanecarboxylate	Daicel Chemical Industries Ltd.
	Oligomer ②	Celoxide 2081	Flexible alicyclic epoxy	
	Oligomer ③	Celoxide 3000	Alicyclic epoxydiluent	
	Oligomer ④	Celoxide 2000	Alicyclic monoepoxy having a vinyl group	
	Oligomer ⑤	Epolead GT301	Polyfunctional alicyclic epoxy (trifunctional)	
	Oligomer ⑥	Epolead GT401	Polyfunctional alicyclic epoxy (tetrafunctional)	
	Oligomer ⑦	EHPE3150	Alicyclic solid epoxy	
	Oligomer ⑧	PB3600	Containing epoxy/vinyl groups	
	Oligomer ⑨	ERL-4221	3,4-Epoxy cyclohexylmethyl-3,4-epoxycyclohexanecarboxylate	Union Carbide Japan K.K.
	Oligomer ⑩	ERL-4299	Flexible alicyclic epoxy	
	Oligomer ⑪	ERL-4206	Alicyclic epoxydiluent	
	Oligomer ⑫	VCMX	Alicyclic monoepoxy having a vinyl group	
	Oligomer ⑬	Epicoat 828	Bisphenol A type epoxy	Yuka-Shell Epoxy Co., Ltd.
	Oligomer ⑭	Epicoat 806	Bisphenol F type epoxy	
	Oligomer ⑮	Epicoat 815	Bisphenol A type epoxy/BGE	
	Oligomer ⑯	Epicoat 834	Bisphenol A type epoxy (semisolid)	
	Oligomer ⑰	Epicoat 1004	Bisphenol A type epoxy (solid)	
	Oligomer ⑱	Epicoat 1001B80	Bisphenol A type epoxy (solution)	
	Oligomer ⑲	Epicoat 5046B80	Flame-retardant epoxy (solution)	
	Oligomer ⑳	Epicoat 152	Polyfunctional epoxy	
	Oligomer (1)	Epicoat 154	Polyfunctional epoxy	
	Oligomer (2)	Epicoat YX310	Tough epoxy	
	Oligomer (3)	850	Bisphenol A type epoxy	Dainippon Ink & Chemicals, Inc.
	Oligomer (4)	830	Bisphenol F type epoxy	
	Oligomer (5)	N-665	Cresol novolak type epoxy	
	Oligomer (6)	N740	Phenol novolak type epoxy	
	Oligomer (7)	ECON-102S	Cresol novolak type epoxy	Nippon Kayaku Co., Ltd.
	Oligomer (8)	ECON-1020	Cresol novolak type epoxy	
	Oligomer (9)	EPPN-201	Phenol novolak type epoxy	
	Oligomer (10)	CY177	Alicyclic epoxy	Ciba-Geigy (Japan) Ltd.
	Oligomer (11)	CY179	Alicyclic epoxy	
	Oligomer (12)	Rapicure CHVE	Vinyl ether	

Table 1 (contd.) List of resin compositions

Type	Composition No.	Product name or code	Remarks	Manufacturer
Photo- and thermopolymerization initiator	Photo-initiator ①	San Aid SI-60L	General formula (I), (II) or (III)	Sanshin Chemical Co., Ltd.
	Photo-initiator ②	San Aid SI-80L		
	Photo-initiator ③	San Aid SI-100L		
	Photo-initiator ④	-	Bis (4-(dimethylsulfonio)phenyl) sulfide bis-hexafluorophosphate (general formula (IV))	-
	Photo-initiator ⑤	-	Dimethyl-4-thiophenoxyphenylsulfonium hexafluoroantimonate (general formula (IV))	-
	Photo-initiator ⑩	-	Dibenzyl-4-hydroxyphenylsulfonium hexafluoroantimonate (general formula (IV))	-
	Photo-initiator ⑪	-	Benzyl-4-(ethoxycarbonyloxy) phenylmethylsulfonium hexafluoroantimonate (general formula (VI))	-
	Photo-initiator ⑫	-	4-Acetoxyphenyldimethylsulfonium hexafluoroantimonate (general formula (VII))	-
Photopolymerization initiator	Photo-initiator ⑥	DAICAT 11	Arylsulfonium salt (hazardous material 3-III, water-insoluble)	Daicel Chemical Industries Ltd.
	Photo-initiator ⑦	CI-2734	Sulfonium salt type (containing γ -butyrolactone)	Nippon Soda Co., Ltd.
	Photo-initiator ⑧	CI-2855	Sulfonium salt type (containing γ -butyrolactone)	
	Photo-initiator ⑨	IRGACURE 261	η^5 -2,4-Cyclopentadien-1-yl ((1,2,3,4,5,6- η)-(1-methylethyl)benzene)-iron(1+)-hexafluorophosphate (1-)	Ciba-Geigy (Japan) Ltd.
	Photo-initiator [13]	-	4,4'-Bis(di β -hydroxyethoxy)phenylsulfonio) phenyl sulfide bis-hexafluoroantimonate	-
Thermopolymerization initiator	Heat-Initiator[14]	-	Prenyltetramethylenesulfonium hexafluoroantimonate (chemical formula (VIII))	-
	Heat-Initiator[15]	-	2-Butynyltetramethylenesulfonium hexafluoroantimonate (chemical formula (IX))	-

Table 2 List of the formulations of resin compositions

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Table 2 (Contd.) List of the formulations of resin compositions

Ex. or Com.Ex. No.	Photopolymerizable resin		Photo- and thermopolymerization initiator		Photopolymerization initiator		Cured wall thickness (max 80 mm)
	Oligomer No.	Proportion (wt. parts)	Photo-initiator No.	Proportion (wt. parts)	Photo-initiator No.	Proportion (wt. parts)	
Ex. 32	Oligomer (13)/ Oligomer (1)	95/5	Photo-initiator (2)	1.75	Photo-initiator (6)	0.75	80
Ex. 33	Oligomer (13)/ Oligomer (1)	75/25					
Ex. 34	Oligomer (13)/ Oligomer (12)	80/20					
Ex. 35	Oligomer (13)/ Oligomer (12)	50/50					
Ex. 36	Oligomer (1)	100	Photo-initiator (1)	1.75	Photo-initiator (7)	0.75	80
Ex. 37			Photo-initiator (3)				
Ex. 38			Photo-initiator (4)				
Ex. 39			Photo-initiator (5)				
Ex. 40	Oligomer (13)	100	Photo-initiator (2)	1.75	Photo-initiator (8)	0.75	80
Ex. 51			Photo-initiator (1)				
Ex. 52			Photo-initiator (3)				
Ex. 53			Photo-initiator (4)				
Ex. 54	Oligomer (13)	100	Photo-initiator (5)	1.75	Photo-initiator (9)	0.75	80
Ex. 55			Photo-initiator (2)				
Ex. 56			Photo-initiator (3)				
Ex. 57			Photo-initiator (4)				
Ex. 58	Oligomer (13)	100	Photo-initiator (5)	1.75	Photo-initiator (6)	0.75	80
Ex. 59			Photo-initiator (2)				
Ex. 60			Photo-initiator (3)				
Ex. 61			Photo-initiator (4)				
Com. Ex. 1	Oligomer (1)	100	Photo-initiator (2)/ Photo-initiator (3)	1.00/0.75	Photo-initiator (7)	0.50/0.25	1
Com. Ex. 2			Photo-initiator (1)				
Com. Ex. 3			Photo-initiator (2)				
Com. Ex. 4			Photo-initiator (3)				
Com. Ex. 5	Oligomer (1)	100	Photo-initiator (4)	2.50	-	2.50	2
Com. Ex. 6			Photo-initiator (5)				
Com. Ex. 7			-				
Com. Ex. 8			-				
Com. Ex. 9	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 10			Photo-initiator (7)				
Com. Ex. 11			Photo-initiator (8)				
Com. Ex. 12			Photo-initiator (9)				
Com. Ex. 13	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 14			Photo-initiator (1)				
Com. Ex. 15			Photo-initiator (2)				
Com. Ex. 16			Photo-initiator (3)				
Com. Ex. 17	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 18			Photo-initiator (5)				
Com. Ex. 19			-				
Com. Ex. 20			-				
Com. Ex. 21	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 22			Photo-initiator (7)				
Com. Ex. 23			Photo-initiator (8)				
Com. Ex. 24			Photo-initiator (9)				
Com. Ex. 25	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 26			Photo-initiator (1)				
Com. Ex. 27			Photo-initiator (2)				
Com. Ex. 28			Photo-initiator (3)				
Com. Ex. 29	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 30			Photo-initiator (5)				
Com. Ex. 31			-				
Com. Ex. 32			-				
Com. Ex. 33	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 34			Photo-initiator (7)				
Com. Ex. 35			Photo-initiator (8)				
Com. Ex. 36			Photo-initiator (9)				
Com. Ex. 37	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 38			Photo-initiator (1)				
Com. Ex. 39			Photo-initiator (2)				
Com. Ex. 40			Photo-initiator (3)				
Com. Ex. 41	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 42			Photo-initiator (5)				
Com. Ex. 43			-				
Com. Ex. 44			-				
Com. Ex. 45	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 46			Photo-initiator (7)				
Com. Ex. 47			Photo-initiator (8)				
Com. Ex. 48			Photo-initiator (9)				
Com. Ex. 49	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 50			Photo-initiator (1)				
Com. Ex. 51			Photo-initiator (2)				
Com. Ex. 52			Photo-initiator (3)				
Com. Ex. 53	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 54			Photo-initiator (5)				
Com. Ex. 55			-				
Com. Ex. 56			-				
Com. Ex. 57	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 58			Photo-initiator (7)				
Com. Ex. 59			Photo-initiator (8)				
Com. Ex. 60			Photo-initiator (9)				
Com. Ex. 61	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 62			Photo-initiator (1)				
Com. Ex. 63			Photo-initiator (2)				
Com. Ex. 64			Photo-initiator (3)				
Com. Ex. 65	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 66			Photo-initiator (5)				
Com. Ex. 67			-				
Com. Ex. 68			-				
Com. Ex. 69	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 70			Photo-initiator (7)				
Com. Ex. 71			Photo-initiator (8)				
Com. Ex. 72			Photo-initiator (9)				
Com. Ex. 73	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 74			Photo-initiator (1)				
Com. Ex. 75			Photo-initiator (2)				
Com. Ex. 76			Photo-initiator (3)				
Com. Ex. 77	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 78			Photo-initiator (5)				
Com. Ex. 79			-				
Com. Ex. 80			-				
Com. Ex. 81	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 82			Photo-initiator (7)				
Com. Ex. 83			Photo-initiator (8)				
Com. Ex. 84			Photo-initiator (9)				
Com. Ex. 85	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 86			Photo-initiator (1)				
Com. Ex. 87			Photo-initiator (2)				
Com. Ex. 88			Photo-initiator (3)				
Com. Ex. 89	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 90			Photo-initiator (5)				
Com. Ex. 91			-				
Com. Ex. 92			-				
Com. Ex. 93	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 94			Photo-initiator (7)				
Com. Ex. 95			Photo-initiator (8)				
Com. Ex. 96			Photo-initiator (9)				
Com. Ex. 97	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 98			Photo-initiator (1)				
Com. Ex. 99			Photo-initiator (2)				
Com. Ex. 100			Photo-initiator (3)				
Com. Ex. 101	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 102			Photo-initiator (5)				
Com. Ex. 103			-				
Com. Ex. 104			-				
Com. Ex. 105	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 106			Photo-initiator (7)				
Com. Ex. 107			Photo-initiator (8)				
Com. Ex. 108			Photo-initiator (9)				
Com. Ex. 109	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 110			Photo-initiator (1)				
Com. Ex. 111			Photo-initiator (2)				
Com. Ex. 112			Photo-initiator (3)				
Com. Ex. 113	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 114			Photo-initiator (5)				
Com. Ex. 115			-				
Com. Ex. 116			-				
Com. Ex. 117	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 118			Photo-initiator (7)				
Com. Ex. 119			Photo-initiator (8)				
Com. Ex. 120			Photo-initiator (9)				
Com. Ex. 121	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 122			Photo-initiator (1)				
Com. Ex. 123			Photo-initiator (2)				
Com. Ex. 124			Photo-initiator (3)				
Com. Ex. 125	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 126			Photo-initiator (5)				
Com. Ex. 127			-				
Com. Ex. 128			-				
Com. Ex. 129	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 130			Photo-initiator (7)				
Com. Ex. 131			Photo-initiator (8)				
Com. Ex. 132			Photo-initiator (9)				
Com. Ex. 133	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 134			Photo-initiator (1)				
Com. Ex. 135			Photo-initiator (2)				
Com. Ex. 136			Photo-initiator (3)				
Com. Ex. 137	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 138			Photo-initiator (5)				
Com. Ex. 139			-				
Com. Ex. 140			-				
Com. Ex. 141	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 142			Photo-initiator (7)				
Com. Ex. 143			Photo-initiator (8)				
Com. Ex. 144			Photo-initiator (9)				
Com. Ex. 145	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 146			Photo-initiator (1)				
Com. Ex. 147			Photo-initiator (2)				
Com. Ex. 148			Photo-initiator (3)				
Com. Ex. 149	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 150			Photo-initiator (5)				
Com. Ex. 151			-				
Com. Ex. 152			-				
Com. Ex. 153	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 154			Photo-initiator (7)				
Com. Ex. 155			Photo-initiator (8)				
Com. Ex. 156			Photo-initiator (9)				
Com. Ex. 157	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 158			Photo-initiator (1)				
Com. Ex. 159			Photo-initiator (2)				
Com. Ex. 160			Photo-initiator (3)				
Com. Ex. 161	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 162			Photo-initiator (5)				
Com. Ex. 163			-				
Com. Ex. 164			-				
Com. Ex. 165	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 166			Photo-initiator (7)				
Com. Ex. 167			Photo-initiator (8)				
Com. Ex. 168			Photo-initiator (9)				
Com. Ex. 169	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 170			Photo-initiator (1)				
Com. Ex. 171			Photo-initiator (2)				
Com. Ex. 172			Photo-initiator (3)				
Com. Ex. 173	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 174			Photo-initiator (5)				
Com. Ex. 175			-				
Com. Ex. 176			-				
Com. Ex. 177	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 178			Photo-initiator (7)				
Com. Ex. 179			Photo-initiator (8)				
Com. Ex. 180			Photo-initiator (9)				
Com. Ex. 181	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 182			Photo-initiator (1)				
Com. Ex. 183			Photo-initiator (2)				
Com. Ex. 184			Photo-initiator (3)				
Com. Ex. 185	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 186			Photo-initiator (5)				
Com. Ex. 187			-				
Com. Ex. 188			-				
Com. Ex. 189	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 190			Photo-initiator (7)				
Com. Ex. 191			Photo-initiator (8)				
Com. Ex. 192			Photo-initiator (9)				
Com. Ex. 193	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 194			Photo-initiator (1)				
Com. Ex. 195			Photo-initiator (2)				
Com. Ex. 196			Photo-initiator (3)				
Com. Ex. 197	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 198			Photo-initiator (5)				
Com. Ex. 199			-				
Com. Ex. 200			-				
Com. Ex. 201	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 202			Photo-initiator (7)				
Com. Ex. 203			Photo-initiator (8)				
Com. Ex. 204			Photo-initiator (9)				
Com. Ex. 205	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 206			Photo-initiator (1)				
Com. Ex. 207			Photo-initiator (2)				
Com. Ex. 208			Photo-initiator (3)				
Com. Ex. 209	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 210			Photo-initiator (5)				
Com. Ex. 211			-				
Com. Ex. 212			-				
Com. Ex. 213	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 214			Photo-initiator (7)				
Com. Ex. 215			Photo-initiator (8)				
Com. Ex. 216			Photo-initiator (9)				
Com. Ex. 217	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 218			Photo-initiator (1)				
Com. Ex. 219			Photo-initiator (2)				
Com. Ex. 220			Photo-initiator (3)				
Com. Ex. 221	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 222			Photo-initiator (5)				
Com. Ex. 223			-				
Com. Ex. 224			-				
Com. Ex. 225	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 226			Photo-initiator (7)				
Com. Ex. 227			Photo-initiator (8)				
Com. Ex. 228			Photo-initiator (9)				
Com. Ex. 229	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 230			Photo-initiator (1)				
Com. Ex. 231			Photo-initiator (2)				
Com. Ex. 232			Photo-initiator (3)				
Com. Ex. 233	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 234			Photo-initiator (5)				
Com. Ex. 235			-				
Com. Ex. 236			-				
Com. Ex. 237	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 238			Photo-initiator (7)				
Com. Ex. 239			Photo-initiator (8)				
Com. Ex. 240			Photo-initiator (9)				
Com. Ex. 241	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 242			Photo-initiator (1)				
Com. Ex. 243			Photo-initiator (2)				
Com. Ex. 244			Photo-initiator (3)				
Com. Ex. 245	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 246			Photo-initiator (5)				
Com. Ex. 247			-				
Com. Ex. 248			-				
Com. Ex. 249	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 250			Photo-initiator (7)				
Com. Ex. 251			Photo-initiator (8)				
Com. Ex. 252			Photo-initiator (9)				
Com. Ex. 253	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 254			Photo-initiator (1)				
Com. Ex. 255			Photo-initiator (2)				
Com. Ex. 256			Photo-initiator (3)				
Com. Ex. 257	Oligomer (13)	100	Photo-initiator (4)	2.50	-	2.50	1
Com. Ex. 258			Photo-initiator (5)				
Com. Ex. 259			-				
Com. Ex. 260			-				
Com. Ex. 261	Oligomer (13)	100	Photo-initiator (6)	0.75	Photo-initiator (5)	1.75	1
Com. Ex. 262			Photo-initiator (7)				
Com. Ex. 263			Photo-initiator (8)				
Com. Ex. 264			Photo-initiator (9)				
Com. Ex. 265	Oligomer (13)	100	Photo-initiator (2)	0.75	Photo-initiator (6)	1.75	1
Com. Ex. 266			Photo-initiator (1)				

Table 3 List of the formulations of two-component photo-initiators and ratings for the cured state

		Photo-initiator (6) (wt. parts)					
		0.4	0.5	0.6	0.7	0.8	0.9
Photo-initiator ② (wt. Parts)	0.4	Ex. 61	Ex. 75	Com. Ex. 36	Com. Ex. 43	Com. Ex. 50	Com. Ex. 57
	Cured state	●	●	x	x	x	x
	0.5	Ex. 62	Ex. 76	Ex. 90	Com. Ex. 44	Com. Ex. 51	Com. Ex. 58
	Cured state	●	●	●	x	x	x
	0.6	Ex. 63	Ex. 77	Ex. 91	Com. Ex. 105	Com. Ex. 52	Com. Ex. 59
	Cured state	●	●	●	●	x	x
	0.7	Ex. 64	Ex. 78	Ex. 92	Ex. 106	Ex. 120	Com. Ex. 60
	Cured state	⊙	●	●	●	●	x
	0.8	Ex. 65	Ex. 79	Ex. 93	Ex. 107	Ex. 121	Ex. 135
	Cured state	⊙	⊙	⊙	●	●	●
	0.9	Ex. 66	Ex. 80	Ex. 94	Ex. 108	Ex. 122	Ex. 136
	Cured state	⊙	⊙	⊙	⊙	●	●
	1.0	Ex. 67	Ex. 81	Ex. 95	Ex. 109	Ex. 123	Ex. 137
	Cured state	⊙	⊙	⊙	⊙	⊙	●
	1.1	Ex. 68	Ex. 82	Ex. 96	Ex. 110	Ex. 124	Ex. 138
	Cured state	⊙	⊙	⊙	⊙	⊙	⊙
	1.2	Ex. 69	Ex. 83	Ex. 97	Ex. 111	Ex. 125	Ex. 139
	Cured state	⊙	⊙	⊙	⊙	⊙	⊙
	1.3	Ex. 70	Ex. 84	Ex. 98	Ex. 112	Ex. 126	Ex. 140
	Cured state	⊙	⊙	⊙	⊙	⊙	⊙
	1.4	Ex. 71	Ex. 85	Ex. 99	Ex. 113	Ex. 127	Ex. 141
	Cured state	⊙	⊙	⊙	⊙	⊙	⊙
	1.5	Ex. 72	Ex. 86	Ex. 100	Ex. 114	Ex. 128	Ex. 142
	Cured state	⊙	⊙	⊙	⊙	⊙	⊙
	1.6	Ex. 73	Ex. 87	Ex. 101	Ex. 115	Ex. 129	Ex. 143
	Cured state	⊙	⊙	⊙	⊙	⊙	⊙
	1.7	Ex. 74	Ex. 88	Ex. 102	Ex. 116	Ex. 130	Ex. 144
	Cured state	○	⊙	⊙	⊙	⊙	⊙
	1.8	Com. Ex. 21	Ex. 89	Ex. 103	Ex. 117	Ex. 131	Ex. 145
	Cured state	▲	○	⊙	⊙	⊙	⊙
	1.9	Com. Ex. 22	Com. Ex. 29	Ex. 104	Ex. 118	Ex. 132	Ex. 146
	Cured state	▲	▲	○	⊙	⊙	⊙
	2.0	Com. Ex. 23	Com. Ex. 30	Com. Ex. 37	Ex. 119	Ex. 133	Ex. 147
	Cured state	▲	▲	▲	○	⊙	⊙
	2.2	Com. Ex. 24	Com. Ex. 31	Com. Ex. 38	Com. Ex. 45	Ex. 134	Ex. 148
	Cured state	▲	▲	▲	▲	○	○
	2.4	Com. Ex. 25	Com. Ex. 32	Com. Ex. 39	Com. Ex. 46	Com. Ex. 53	Com. Ex. 61
	Cured state	▲	▲	▲	▲	▲	▲
	2.6	Com. Ex. 26	Com. Ex. 33	Com. Ex. 40	Com. Ex. 47	Com. Ex. 54	Com. Ex. 62
	Cured state	▲	▲	▲	▲	▲	▲
	2.8	Com. Ex. 27	Com. Ex. 34	Com. Ex. 41	Com. Ex. 48	Com. Ex. 55	Com. Ex. 63
	Cured state	▲	▲	▲	▲	▲	▲
	3.0	Com. Ex. 28	Com. Ex. 35	Com. Ex. 42	Com. Ex. 49	Com. Ex. 56	Com. Ex. 64
	Cured state	▲	▲	▲	▲	▲	▲

Photopolymerizable resin component: Oligomer (1), 100 parts by weight.

Rating system for the cured state: ⊙ Completely cured to 80 mm; ○ Completely cured to 80 mm (but cracked); ● Cured to 80 mm (but with a low hardness);

▲ Cured to 80 mm (but formed like millet cake); x The internal part remained uncured (cured only in an about 1 mm thick surface layer).

Table 3 (Contd.) List of the formulations of two-component photo-initiators and ratings for the cured state

		Photo-initiator (6) (wt. parts)				
		1.0	1.1	1.2	1.3	1.4
Photo-initiator (2) (wt. Parts)	0.4	Com. Ex. 65	Com. Ex. 74	Com. Ex. 83	Com. Ex. 93	Com. Ex. 104
	Cured state	x	x	x	x	x
	0.5	Com. Ex. 66	Com. Ex. 75	Com. Ex. 84	Com. Ex. 94	Com. Ex. 105
	Cured state	x	x	x	x	x
	0.6	Com. Ex. 67	Com. Ex. 76	Com. Ex. 85	Com. Ex. 95	Com. Ex. 106
	Cured state	x	x	x	x	x
	0.7	Com. Ex. 68	Com. Ex. 77	Com. Ex. 86	Com. Ex. 96	Com. Ex. 107
	Cured state	x	x	x	x	x
	0.8	Com. Ex. 69	Com. Ex. 78	Com. Ex. 87	Com. Ex. 97	Com. Ex. 108
	Cured state	x	x	x	x	x
	0.9	Ex. 149	Com. Ex. 79	Com. Ex. 88	Com. Ex. 98	Com. Ex. 109
	Cured state	●	x	x	x	x
	1.0	Ex. 150	Ex. 162	Com. Ex. 89	Com. Ex. 99	Com. Ex. 110
	Cured state	●	●	x	x	x
	1.1	Ex. 151	Ex. 163	Ex. 175	Com. Ex. 100	Com. Ex. 111
	Cured state	●	●	●	x	x
	1.2	Ex. 152	Ex. 164	Ex. 176	Ex. 187	Com. Ex. 112
	Cured state	⊙	⊙	●	●	x
	1.3	Ex. 153	Ex. 165	Ex. 177	Ex. 188	Ex. 198
	Cured state	⊙	⊙	⊙	●	●
	1.4	Ex. 154	Ex. 166	Ex. 178	Ex. 189	Ex. 199
	Cured state	⊙	⊙	⊙	⊙	⊙
	1.5	Ex. 155	Ex. 167	Ex. 179	Ex. 190	Ex. 200
	Cured state	⊙	⊙	⊙	⊙	⊙
	1.6	Ex. 156	Ex. 168	Ex. 180	Ex. 191	Ex. 201
	Cured state	⊙	⊙	⊙	⊙	⊙
	1.7	Ex. 157	Ex. 169	Ex. 181	Ex. 192	Ex. 202
	Cured state	⊙	⊙	⊙	⊙	⊙
	1.8	Ex. 158	Ex. 170	Ex. 182	Ex. 193	Ex. 203
	Cured state	⊙	⊙	⊙	⊙	⊙
	1.9	Ex. 159	Ex. 171	Ex. 183	Ex. 194	Ex. 204
	Cured state	⊙	⊙	⊙	⊙	⊙
	2.0	Ex. 160	Ex. 172	Ex. 184	Ex. 195	Ex. 205
	Cured state	⊙	⊙	⊙	⊙	⊙
	2.2	Ex. 161	Ex. 173	Ex. 185	Ex. 196	Ex. 206
	Cured state	○	⊙	⊙	⊙	⊙
	2.4	Com. Ex. 70	Ex. 174	Ex. 186	Ex. 197	Ex. 207
	Cured state	▲	○	○	○	○
	2.6	Com. Ex. 71	Com. Ex. 80	Com. Ex. 90	Com. Ex. 101	Com. Ex. 113
	Cured state	▲	▲	▲	▲	▲
	2.8	Com. Ex. 72	Com. Ex. 81	Com. Ex. 91	Com. Ex. 102	Com. Ex. 114
	Cured state	▲	▲	▲	▲	▲
	3.0	Com. Ex. 73	Com. Ex. 82	Com. Ex. 92	Com. Ex. 103	Com. Ex. 115
	Cured state	▲	▲	▲	▲	▲

Photopolymerizable resin component: Oligomer (1), 100 parts by weight.

Rating system for the cured state: ⊙ Completely cured to 80 mm; ○ Completely cured to 80 mm (but cracked); ● Cured to 80 mm (but with a low hardness);

▲ Cured to 80 mm (but formed like millet cake); x The internal part remained uncured (cured only in an about 1 mm thick surface layer).

Table 3 (Contd.) List of the formulations of two-component photo-initiators and ratings for the cured state

		Photo-initiator (6) (wt. parts)				
		1.5	1.7	1.8	2.0	2.2
Photo-initiator (2) (wt. Parts)	0.4	Com. Ex. 116	Com. Ex. 129	Com. Ex. 143	Com. Ex. 157	Com. Ex. 172
	Cured state	x	x	x	x	x
	0.5	Com. Ex. 117	Com. Ex. 130	Com. Ex. 144	Com. Ex. 158	Com. Ex. 173
	Cured state	x	x	x	x	x
	0.6	Com. Ex. 118	Com. Ex. 131	Com. Ex. 145	Com. Ex. 159	Com. Ex. 174
	Cured state	x	x	x	x	x
	0.7	Com. Ex. 119	Com. Ex. 132	Com. Ex. 146	Com. Ex. 160	Com. Ex. 175
	Cured state	x	x	x	x	x
	0.8	Com. Ex. 120	Com. Ex. 133	Com. Ex. 147	Com. Ex. 161	Com. Ex. 176
	Cured state	x	x	x	x	x
	0.9	Com. Ex. 121	Com. Ex. 134	Com. Ex. 148	Com. Ex. 162	Com. Ex. 177
	Cured state	x	x	x	x	x
	1.0	Com. Ex. 122	Com. Ex. 135	Com. Ex. 149	Com. Ex. 163	Com. Ex. 178
	Cured state	x	x	x	x	x
	1.1	Com. Ex. 123	Com. Ex. 136	Com. Ex. 150	Com. Ex. 164	Com. Ex. 179
	Cured state	x	x	x	x	x
	1.2	Com. Ex. 124	Com. Ex. 137	Com. Ex. 151	Com. Ex. 165	Com. Ex. 180
	Cured state	x	x	x	x	x
	1.3	Com. Ex. 125	Com. Ex. 138	Com. Ex. 152	Com. Ex. 166	Com. Ex. 181
	Cured state	x	x	x	x	x
	1.4	Ex. 208	Com. Ex. 139	Com. Ex. 153	Com. Ex. 167	Com. Ex. 182
	Cured state	●	x	x	x	x
	1.5	Ex. 209	Com. Ex. 140	Com. Ex. 154	Com. Ex. 168	Com. Ex. 183
	Cured state	⊙	x	x	x	x
	1.6	Ex. 210	Ex. 217	Com. Ex. 155	Com. Ex. 169	Com. Ex. 184
	Cured state	⊙	●	x	x	x
	1.7	Ex. 211	Ex. 218	Ex. 225	Com. Ex. 170	Com. Ex. 185
	Cured state	⊙	⊙	●	x	x
	1.8	Ex. 212	Ex. 219	Ex. 226	Ex. 233	Com. Ex. 186
	Cured state	⊙	⊙	⊙	●	x
	1.9	Ex. 213	Ex. 220	Ex. 227	Ex. 234	Com. Ex. 187
	Cured state	⊙	⊙	⊙	●	x
	2.0	Ex. 214	Ex. 221	Ex. 228	Ex. 235	Ex. 240
	Cured state	⊙	⊙	⊙	⊙	●
	2.2	Ex. 215	Ex. 222	Ex. 229	Ex. 236	Ex. 241
	Cured state	⊙	⊙	⊙	⊙	⊙
	2.4	Ex. 216	Ex. 223	Ex. 230	Ex. 237	Ex. 242
	Cured state	⊙	⊙	⊙	⊙	⊙
	2.6	Com. Ex. 126	Ex. 224	Ex. 231	Ex. 238	Ex. 243
	Cured state	▲	○	○	⊙	⊙
	2.8	Com. Ex. 127	Com. Ex. 141	Ex. 232	Ex. 239	Ex. 244
	Cured state	▲	▲	○	○	○
	3.0	Com. Ex. 128	Com. Ex. 142	Com. Ex. 156	Com. Ex. 171	Ex. 245
	Cured state	▲	▲	▲	▲	○

Photopolymerizable resin component: Oligomer (1), 100 parts by weight.

Rating system for the cured state: ⊙ Completely cured to 80 mm; ○ Completely cured to 80 mm (but cracked); ● Cured to 80 mm (but with a low hardness);

▲ Cured to 80 mm (but formed like millet cake); x The internal part remained uncured (cured only in an about 1 mm thick surface layer).

Table 4

List of resin compositions and samples for measuring the resin temperature during curing	
	Composition No.
Comparative Example 24	Composition No. ①
Comparative Example 37	Composition No. ②
Example 130	Composition No. ③
Example 143	Composition No. ④
Example 155	Composition No. ⑤
Example 166	Composition No. ⑥
Comparative Example 89	Composition No. ⑦
Comparative Example 59	Composition No. ⑧
Example 110	Composition No. ⑨
Example 125	Composition No. ⑩
Example 182	Composition No. ⑪

Example 246

[0044] The same resin composition as described in Example 1(A) was prepared, and a sample was constructed in the same manner as described in Example 1(B).

[0045] This sample was irradiated with UV radiation under the same conditions as described in Example 1(C), except that the irradiation distance was 25 cm.

[0046] After UV irradiation, the resin within the glass vessel was completely cured in several minutes. The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass vessel (see FIG. 11).

Example 247

[0047] The same resin composition as described in Example 1(A) was prepared, and a sample was constructed in the same manner as described in Example 1(B).

[0048] This sample was irradiated with UV radiation under the same conditions as described in Example 1(C), except that the irradiation distance was 20 cm.

[0049] After UV irradiation, the resin within the glass vessel was completely cured in several minutes. The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass vessel (see FIG. 11).

Example 248

[0050] The same resin composition as described in Example 1(A) was prepared, and a sample was constructed in the same manner as described in Example 1(B).

[0051] This sample was irradiated with UV radiation under the same conditions as described in Example 1(C), except that the irradiation distance was 15 cm.

[0052] After UV irradiation, the resin within the glass vessel was completely cured in several minutes. The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass vessel (see FIG. 11).

Example 249

[0053] The same resin composition as described in Example 1(A) was prepared, and a sample was constructed in the same manner as described in Example 1(B).

(D) This sample was irradiated with UV radiation under the following conditions.

Ultraviolet irradiator: UVL-3500 M2 (manufactured by Ushio Inc.)

Type of lamp: Metal halide lamp.

Intensity of lamp: 120 W/cm.

Length of lamp: 250 mm.

Atmosphere, temperature and pressure: Air, room temperature and atmospheric pressure.

Irradiation distance: 19 cm.

Irradiation time: 60 seconds.

[0054] After UV irradiation, the resin within the glass vessel was completely cured in several minutes. The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass vessel.

Example 250

[0055] The same resin composition as described in Example 1(A) was prepared, and a sample was constructed in the same manner as described in Example 1(B).

[0056] This sample was irradiated with UV radiation under the same conditions as described in Example 247(D), except that the intensity of the lamp was 200 W/cm.

[0057] After UV irradiation, the resin within the glass vessel was completely cured in several minutes. The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass vessel.

Example 251

[0058] The same resin composition as described in Example 1(A) was prepared, and a sample was constructed in the same manner as described in Example 1(B).

[0059] This sample was irradiated with UV radiation under the same conditions as described in Example 247(D), except that the intensity of the lamp was 280 W/cm.

[0060] After UV irradiation, the resin within the glass vessel was completely cured in several minutes. The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass vessel.

Example 252

[0061]

(E) The same resin composition as described in Example 1(A) was prepared and used as a matrix resin. Then, pre-pregs were made by impregnating 18 cm x 18 pieces of CF cloth with this matrix resin.

(E) A prepreg laminate sample was made by stacking 40 such pre-pregs (to a thickness of about 8 mm), interposing them between glass plates through the medium of bag films, and applying weight thereto from above (FIG. 12).

[0062] This sample was irradiated with UV radiation under the same conditions as described in Example 1(C), except that the irradiation time was 3 minutes and the irradiation distance was 15 cm.

[0063] After UV irradiation, the laminate was completely cured to give a satisfactory CFRP (the related data are shown in Table 5).

Table 5

Data on Properties of FRPs		
Item	GFRP	CFRP
Tensile strength (kgf/cm ²)	3100	7100
Bending strength (kgf/cm ²)	3400	3000
Fiber content (wt. %)	59.2	52.3
Fiber content (vol. %)	38.0	41.7
Specific gravity (g/cm ³)	1.71	1.43

Table 5 (continued)

Data on Properties of FRPs		
Item	GFRP	CFRP
Void fraction (vol. %)	1.99	0.73
Heat resistance (Tg:°C)	150	150
Torsional elastic modulus (GPa)	2.2	2.2

Example 253

[0064] A prepreg laminate sample (with a thickness of about 8 mm) was made in the same manner as described in Example 252(E), except that 18 x 18 of GF cloth were used as the reinforcing fibrous material.

[0065] This sample was irradiated with UV radiation under the same conditions as described in Example 252.

[0066] After UV irradiation, the laminate was completely cured to give a satisfactory GFRP (the related data are shown in Table 5).

Example 254

[0067] A prepreg laminate sample was made in the same manner as described in Example 252(E), except that 100 prepreps were stacked (to a thickness of about 20 mm)

[0068] This sample was irradiated with UV radiation under the same conditions as described in Example 252.

[0069] After UV irradiation, the laminate was completely cured to give a satisfactory CFRP.

Example 255

[0070] A prepreg laminate sample was made in the same manner as described in Example 252(E), except that the resin composition of Example 13 was used as the matrix resin.

[0071] This sample was irradiated with UV radiation under the same conditions as described in Example 252.

[0072] After UV irradiation, the laminate was completely cured to give a satisfactory CFRP.

Example 256

[0073] A prepreg laminate sample was made in the same manner as described in Example 252(E).

[0074] An electron beam (EB) was used as the energy radiation. The EB irradiation was carried out under the following conditions.

Irradiator: Linac (High Voltage Alco, Ltd.).

Beam energy: 10 MeV.

Scanning frequency: 4 Hz.

Pulse repetition rate: 60 Hz.

Scanning width: 20 cm.

Pulse width: 4 μ sec.

Radiation dose: 50 kGy.

[0075] After UV irradiation, the laminate was completely cured to give a satisfactory CFRP.

Example 257

[0076]

(F) A matrix resin was prepared in the same manner as described in Example 252(E). Carbon fiber was impregnated with this matrix resin and then wound at a winding speed of 30 cm/sec (according to a filament winding technique) to form a cylindrical laminate material made of CFRP (with a wall thickness of 3 mm).

[0077] After completion of the winding, the cylindrical laminate material was irradiated with UV radiation from all directions (under the same conditions as described in Example 252).

[0078] After UV irradiation, the laminate material was completely cured to give a satisfactory filament-wound CFRP.

Example 258

5 [0079] A cylindrical laminate material made of CFRP (with a wall thickness of 3 mm) was formed in the same manner as described in Example 257(F), except that glass fiber was used as the reinforcing fiber.

[0080] After completion of the winding, the cylindrical laminate material was irradiated with UV radiation from all directions (under the same conditions as described in Example 252).

[0081] After UV irradiation, the laminate material was completely cured to give a satisfactory filament-wound GFRP.

Example 259

15 [0082] Using a resin composition prepared by mixing 100 parts by weight of Celoxide 2021P (oligomer ①; an alicyclic epoxy resin manufactured by Daicel Chemical Industries Ltd.; 3,4-cyclohexylmethyl 3,4-epoxycyclohexanecarboxylate) with 1.50 parts by weight of San Aid SI-80L {photo-initiator ②; a cationic photo- and thermopolymerization initiator manufactured by Sanshin Chemical Co., Ltd.; general formula (II)}, 0.50 part by weight of DAICAT 11 (photo-initiator ⑥; a cationic photopolymerization initiator manufactured by Daicel Chemical Industries Ltd.; an arylsulfonium salt), 0.50 part by weight of 4,4'-bis(di(β-hydroxyethoxy)phenylsulfonio)phenyl sulfide bis-hexafluoroantimonate (photo-initiator ③), and 0.50 part by weight of 2-butynyldimethylsulfonium hexafluoroantimonate {photo-initiator ⑨; general formula (IX)}, a test was carried out under the same conditions as described in Example 1.

20 [0083] After UV irradiation, the resin within the glass vessel was completely cured in several minutes. The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass vessel.

Example 260

25 [0084] Using a resin composition prepared by mixing 100 parts by weight of Celoxide 2021P (oligomer ①; an alicyclic epoxy resin manufactured by Daicel Chemical Industries Ltd.; 3,4-cyclohexylmethyl 3,4-epoxycyclohexanecarboxylate) with 1.50 parts by weight of San Aid SI-80L {photo-initiator ②; a cationic photo- and thermopolymerization initiator manufactured by Sanshin Chemical Co., Ltd.; general formula (II)}, 1.00 part by weight of DAICAT 11 (photo-initiator ⑥; a cationic photopolymerization initiator manufactured by Daicel Chemical Industries Ltd.; an arylsulfonium salt), and 0.50 part by weight of prenyldimethylsulfonium hexafluoroantimonate {photo-initiator ⑭; general formula (VIII)}, a test was carried out under the same conditions as described in Example 1.

30 [0085] After UV irradiation, the resin within the glass vessel was completely cured in several minutes. The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass vessel.

Comparative Examples 188 to 190

[0086] Tests were carried out in all the same manner as described in Examples 246 to 248, except that the composition of Comparative Example 1 was used as the resin composition.

40 [0087] After UV irradiation, the wall thickness of the resin was about 1 mm, and its inner part remained uncured (see FIG. 11).

Comparative Example 191

45 [0088] A prepreg laminate sample was made in the same manner as described in Example 252(E), except that the resin composition of Comparative Example 1 was used as the matrix resin.

[0089] This sample was irradiated with UV radiation under the same conditions as described in Example 252.

[0090] After UV irradiation, the CFRP was cured only in the first surface layer on the irradiated side, and the inner part of the resin remained entirely uncured.

Comparative Example 192

[0091] A prepreg laminate sample was made in the same manner as described in Example 253, except that the resin composition of Comparative Example 1 was used as the matrix resin.

55 [0092] This sample was irradiated with UV radiation under the same conditions as described in Example 252.

[0093] After UV irradiation, the GFRP was cured only up to the second or third layer on the irradiated side, and the inner part of the resin remained entirely uncured.

Examples 261 to 282

[0094] Tests were carried out under the same conditions as described in Example 1, except that the resin compositions shown in Table 1 were used and tested according to the formulations shown in Tables 6 (continued from Table 2).

5 The test results thus obtained are shown in Table 6.

Table 6 List of the formulations of resin compositions (continued from Table 2)

Ex. or Com.Ex. No.	Photopolymerizable resin		Photo- and thermopolymerization initiator		Photo-and thermopolymerization initiator		Cured wall thickness (mm)
	Oligomer No.	Proportion (wt. parts)	Photo-initiator No.	Proportion (wt. parts)	Photo-initiator No.	Proportion (wt. parts)	
Ex. 281	Oligomer (3)/ Oligomer (1)	50/50	Photo-initiator (2)	1:75	Photo-initiator (5)	0.75	80
Ex. 282	Oligomer (4)/ Oligomer (1)						
Ex. 283	Oligomer (5)/ Oligomer (1)						
Ex. 284	Oligomer (5)/ Oligomer (1)						
Ex. 285	Oligomer (10)/ Oligomer (1)						
Ex. 286	Oligomer (18)/ Oligomer (1)						
Ex. 287	Oligomer (13)/ Oligomer (1)						
Ex. 288	Oligomer (20)/ Oligomer (1)						
Ex. 289	Oligomer (11)/ Oligomer (1)						
Ex. 290	Oligomer (21)/ Oligomer (1)						
Ex. 291	Oligomer (31)/ Oligomer (1)						
Ex. 292	Oligomer (41)/ Oligomer (1)						
Ex. 293	Oligomer (51)/ Oligomer (1)						
Ex. 294	Oligomer (61)/ Oligomer (1)						
Ex. 295	Oligomer (71)/ Oligomer (1)						
Ex. 296	Oligomer (81)/ Oligomer (1)						
Ex. 297	Oligomer (91)/ Oligomer (1)						
Ex. 298	Oligomer (101)/ Oligomer (1)						
Ex. 299	Oligomer (111)/ Oligomer (1)						
Ex. 280	Oligomer (1)	100	Photo-initiator (10)				
Ex. 281			Photo-initiator (11)				
Ex. 282			Photo-initiator (12)				

Example 283

[0095] The same resin composition as described in Example 1(A) was prepared, and a sample was constructed in the same manner as described in Example 1(B).

[0096] The constructed sample was heated in an oven kept at 150°C, instead of being irradiated with energy radiation.

[0097] The resin within the glass vessel was completely cured in a little less than 10 minutes after the start of heating. The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass ves-

sel.

Example 284

[0098] The same resin composition as described in Example 1(A) was prepared, and a sample was constructed in the same manner as described in Example 1(B).

[0099] The constructed sample was placed in an oven adjusted to a temperature in a range which did not cause its cure (60°C in this example), and held therein until the resin temperature became equal to the temperature of the atmosphere within the oven. Thereafter, the sample was taken out of the oven and tested under the same conditions as described in Example 1.

[0100] After DV irradiation, the resin within the glass vessel was completely cured in several minutes (in a shorter time than in Example 1). The wall thickness of the resin was 80 mm (the greatest measurable value) which was the limit defined by the glass vessel.

INDUSTRIAL APPLICABILITY

Resin composition capable of inducing the novel resin curing mechanism

[0101] It can be seen from the test results of Examples 1-60, Examples 259-282 and Comparative Examples 1-20 shown in Tables 1-3 and Table 6 that the compositions of the present invention involving the novel resin curing mechanism are excellent in energy radiation curability, particularly thick-wall curability. Moreover, it can be seen from Example 284 that it is more effective for curing purposes to warm a composition of the present invention previously (in a temperature range which does not cause its cure) and then expose it to energy radiation. Furthermore, it has been confirmed by Example 283 that a composition of the present invention containing a photopolymerization initiator comprising at least two components can also be cured in a short period of time by the application of heat.

Photopolymerization initiator systems comprising at least two components capable of inducing the novel resin curing mechanism and their proper compositional range

[0102] The effectiveness of photopolymerization initiator systems comprising at least two components capable of inducing the novel resin curing mechanism and their proper compositional range are evident from the test results of Examples 1-245 and Comparative Examples 1-187 shown in Tables 1-3 and FIG. 9.

Verification of the novel resin curing mechanism

[0103] Among the results of Examples 1-245 and Comparative Examples 1-187, curves showing a rise in resin temperature due to the curing heat exotherm of the resin when each of the compositions shown in Table 4 was exposed to energy radiation are depicted in FIG. 10. Moreover, curves showing a rise in resin temperature due to the curing exotherm of the resin when each of the compositions of Examples 246-248 and Comparative Examples 188-190 was exposed to energy radiation are depicted in FIG. 11. It is evident from FIGs. 10 and 11 that the resin compositions of the present invention are cured on the basis of the novel resin curing mechanism in which energy other than the energy from the energy radiation source, i.e. heat energy arising from the heat of curing reaction (curing exotherm) in this case, is autogenously generated within the resin, so that the resin composition is cured by means of both the heat energy arising from the curing reaction and the energy from the energy radiation source.

[0104] Moreover, it can be confirmed by the test results of Examples 246-251 that the novel resin curing mechanism of the present invention is effective even if the conditions of irradiation with energy radiation are varied.

Verification of the curability of CFRPs (thick-walled resins containing an energy radiation screening substance) and GFRPs

[0105] It is evident from the results of Examples 252-258 and Comparative Examples 191-192 that the photo-curing (energy radiation curing) of CFRPs (thick-walled resins containing an energy radiation screening substance) and the photo-curing (energy radiation curing) of GFRPs and the like, which have been impossible with conventional photo-curable resins, can be achieved by the novel resin curing mechanism of the present invention and the photopolymerization initiator systems comprising at least two components and resin compositions which are capable of inducing this mechanism.

[0106] Moreover, it can be confirmed by Example 256 that the novel resin curing mechanism of the present invention, the photopolymerization initiator systems comprising at least two components and resin compositions which are capa-

ble of inducing this mechanism, and the method of making FRPs (CFRPs) in accordance with the present invention may also be applied to the EB curing of FRPs (CFRPs).

[0107] Furthermore, it is evident from Example 257 that the method of making FRPs (CFRPs) in accordance with the present invention may be applied not only to a lay-up process, but also to other FRP molding processes such as a filament winding process.

Molded articles of CFRP and GFRP made according to the present invention

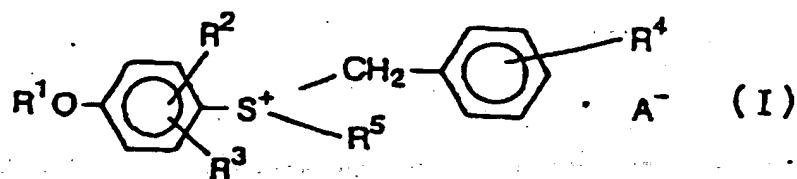
[0108] Basic properties of the CFRP and GFRP made in Examples 252 and 253 were measured, and the results are shown in Table 5. It can be seen from Table 5 that they were satisfactory samples.

Claims

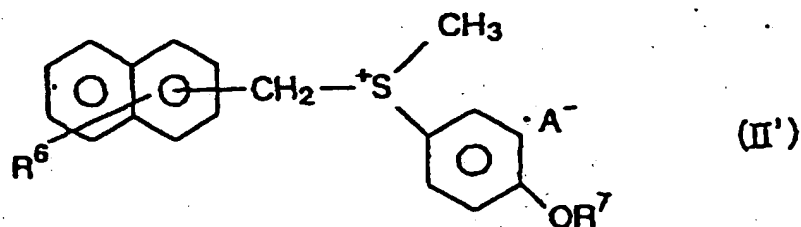
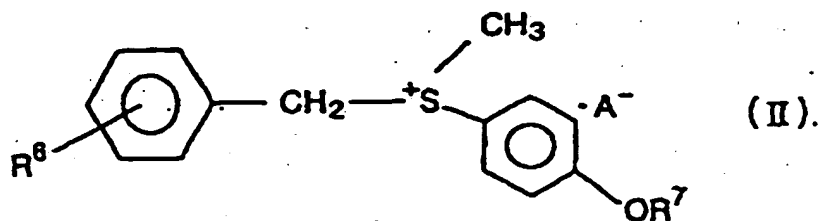
1. A resin curing method wherein, when energy is applied to a resin composition, another kind of energy than the energy from an external energy source is autogenously generated within the resin composition, so that the resin composition is cured by means of the autogenously generated energy, or both the autogenously generated energy and the energy from the external energy source, whether or not the resin composition contains a substance capable of screening the energy from the external energy source.
2. A resin curing method wherein, when energy is applied to a resin composition, another kind of first energy than the energy from an external energy source is autogenously generated within the resin composition, and the same kind of second energy is successively generated by the autogenously generated first energy, so that the resin composition is cured by means of the first and second energies, or both the first and second energies and the energy from the external energy source, whether or not the resin composition contains a substance capable of screening the energy from the external energy source.
3. A resin curing method wherein, when a resin composition is exposed to energy radiation, another kind of energy than the energy from an external energy radiation source is autogenously generated within the resin composition, so that the resin composition is cured by means of the autogenously generated energy, or both the autogenously generated energy and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation.
4. A resin curing method wherein, when a resin composition is exposed to energy radiation, another kind of first energy than the energy from an external energy radiation source is autogenously generated within the resin composition, and the same kind of second energy is successively generated by the autogenously generated first energy, so that the resin composition is cured by means of the first and second energies, or both the first and second energies and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation.
5. A resin curing method as claimed in claim 3 wherein the kind of energy autogenously generated within the resin composition is heat energy, so that the resin composition is cured by means of the heat energy, or both the heat energy and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation.
6. A resin curing method as claimed in claim 4 wherein the kind of energy autogenously generated within the resin composition is heat energy, and a second heat energy is successively generated by the generated first heat energy, so that the resin composition is cured by means of the first and second heat energies, or both the first and second heat energies and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation.
7. A resin curing method as claimed in claim 5 wherein the heat energy autogenously generated within the resin composition is curing reaction heat energy generated when the resin composition is cured by exposure to energy radiation, so that the resin composition is cured by means of the reaction heat energy, or both the reaction heat energy and the energy from the external energy radiation source.
8. A resin curing method as claimed in claim 6 wherein the first heat energy autogenously generated within the resin composition is curing reaction heat energy generated when the resin composition is cured by exposure to the external energy radiation, and the successively generated second heat energy is curing reaction heat energy succes-

sively generated by utilizing the above curing reaction heat energy to further effect the curing reaction like a chain reaction, so that the resin composition is cured by means of the first and second reaction heat energies, or both the first and second reaction heat energies and the energy from the energy radiation source.

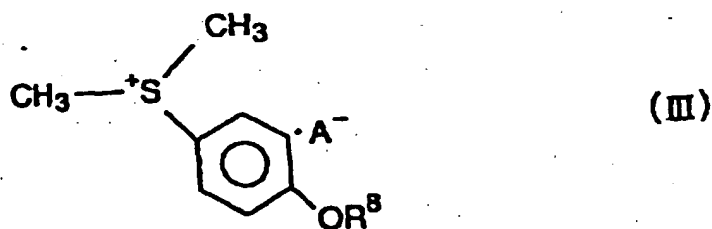
- 5 9. A resin curing method as claimed in any of claims 1 to 4 wherein at least one species selected from the group consisting of a cation, a radical and an anion is utilized during the curing process.
- 10 10. A resin curing method as claimed in claim 6 wherein, when the resin composition is exposed to the external energy radiation, a cation and a first curing reaction heat energy due to the cure of the resin composition are generated within the resin composition, and a cation and a second curing reaction heat energy are successively generated by utilizing the above cation and the first curing reaction heat energy to further effect the curing reaction like a chain reaction, so that the resin composition is cured by means of the first and second reaction heat energies and the cation, or the combination of the first and second reaction heat energies, the cation, and the energy from the external energy radiation source.
- 15 11. A resin curing method as claimed in any of claims 1 to 4 wherein the resin composition is previously warmed in a temperature range which does not cause its cure.
- 20 12. A resin curing method as claimed in any of claims 1 to 4 wherein the resin composition contains a polymerization initiator.
- 25 13. A resin curing method as claimed in claim 12 wherein the cure of the resin composition is initiated by means of heat or the resin composition is cured by means of heat.
- 30 14. A photopolymerization initiator comprising at least two components including a photopolymerization initiator and a photo- and thermopolymerization initiator for initiating polymerization by means of both light and heat, and serving as the polymerization initiator making it possible to carry out a resin curing method as claimed in claim 12.
- 35 15. A photopolymerization initiator comprising at least two components as claimed in claim 14 wherein the photo- and thermopolymerization initiator is a photo- and thermopolymerization initiator having a powerful polymerization-initiating effect upon exposure to heat.
- 40 16. A photopolymerization initiator comprising at least two components as claimed in claim 14 which includes at least one of the photopolymerization initiators comprising at least two components, and a thermopolymerization initiator.
- 45 17. A photopolymerization initiator comprising at least two components as claimed in claim 14 which consists essentially or entirely of radical polymerization initiators.
- 50 18. A photopolymerization initiator comprising at least two components as claimed in claim 14 which consists essentially or entirely of anionic polymerization initiators.
- 55 19. A photopolymerization initiator comprising at least two components as claimed in claim 14 which consists essentially or entirely of cationic polymerization initiators.
20. A photopolymerization initiator comprising at least two components as claimed in claim 19 wherein the photopolymerization initiator comprises at least one compound selected from a diazonium salt type compound, an iodonium salt type compound, a pyridinium salt type compound, a phosphonium salt type compound, a sulfonium salt type compound, an iron-arene complex type compound, and a sulfonate type compound, and the photo- and thermopolymerization initiator comprises at least one of the sulfonium salts represented by the following general formulae (I) to (VII).



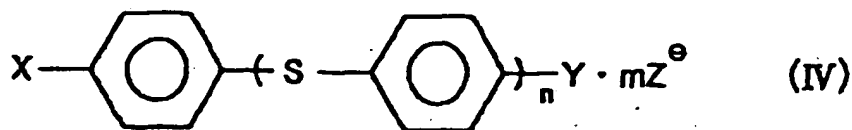
10 where R^1 represents hydrogen, methyl, acetyl or methoxycarbonyl, R^2 and R^3 each independently represents hydrogen, halogen or an alkyl group of 1 to 4 carbon atoms, R^4 represents hydrogen, halogen or methoxy, R^5 represents an alkyl group of 1 to 4 carbon atoms, and A represents SbF_6 , PF_6 , AsF_6 or BF_4 .



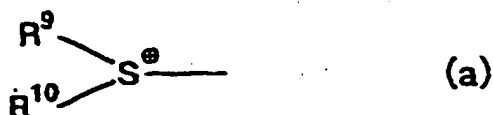
35 where R^6 represents a hydrogen atom, a halogen atom, a nitro group or a methyl group, R^7 represents a hydrogen atom, CH_3CO or CH_3OCO , and A represents SbF_6 , PF_6 , BF_6 or AsF_6 .



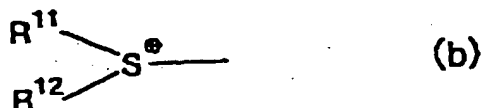
where R^8 represents a hydrogen atom, CH_3CO or CH_3OCO , and A represents SbF_6 , PF_6 , BF_6 , AsF_6 or CH_3SO_4 .



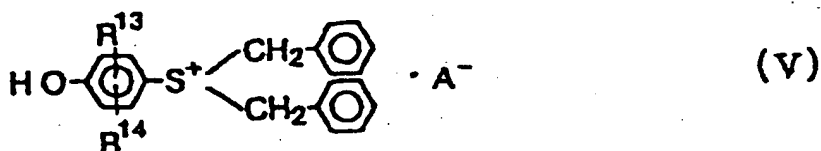
where X represents a sulfonio group of the general formula



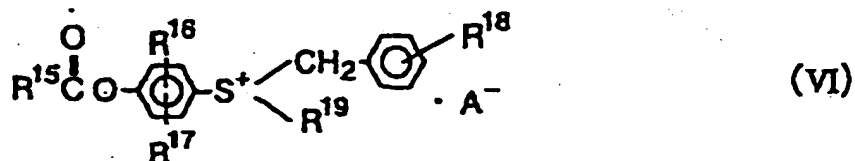
in which R^9 represents an aliphatic group of 1 to 18 carbon atoms, R^{10} represents an aliphatic group of 1 to 18 carbon atoms or a substituted or unsubstituted aromatic group of 6 to 18 carbon atoms, and R^9 and R^{10} may be joined together to form a ring; Y represents a sulfonio group of the general formula



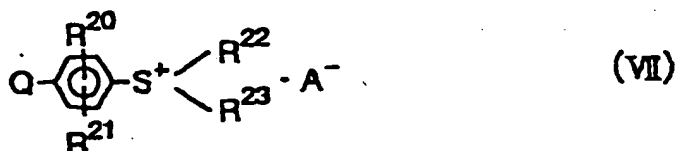
in which R^{11} represents an aliphatic group of 1 to 18 carbon atoms, R^{12} represents an aliphatic group of 1 to 18 carbon atoms or a substituted or unsubstituted aromatic group of 6 to 18 carbon atoms, and R^{11} and R^{12} may be joined together to form a ring, or Y represents a hydrogen atom, a halogen atom, a nitro group, an alkoxy group, an aliphatic group of 1 to 18 carbon atoms, or a substituted or unsubstituted phenyl, phenoxy or thiophenoxy group of 6 to 18 carbon atoms; n and m are each independently 1 or 2; and Z is an anion represented by the formula $\text{MQ}_{l(\text{el})}$ or $\text{MQ}_{l(\text{el})}\text{-OH}$ in which M is B, P, As or Sb, Q is a halogen atom, and $l(\text{el})$ is 4 or 6.



where R^{13} and R^{14} each independently represents hydrogen or an alkyl group of 1 to 4 carbon atoms, and A represents SbF_6 , PF_6 or AsF_6 .



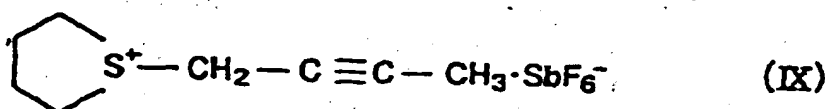
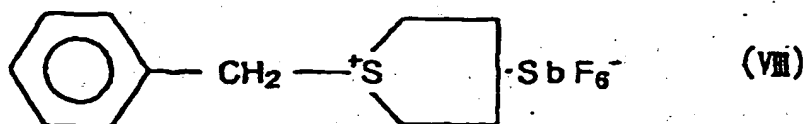
where R^{15} represents ethoxy, phenyl, phenoxy, benzyloxy, chloromethyl, dichloromethyl, trichloromethyl or trifluoromethyl, R^{16} and R^{17} each independently represents hydrogen, halogen or an alkyl group of 1 to 4 carbon atoms, R^{18} represents hydrogen, methyl, methoxy or halogen, R^{19} represents an alkyl group of 1 to 4 carbon atoms, and A represents SbF_6 , PF_6 , BF_4 or AsF_6 .



where Q represents methoxycarbonyloxy, acetoxy, benzyloxycarbonyloxy or dimethylamino, R^{20} and R^{21} each independently represents hydrogen or an alkyl group of 1 to 4 carbon atoms, R^{22} and R^{23} each independently rep-

resents an alkyl group of 1 to 4 carbon atoms, and A represents SbF_6 , PF_6 , AsF_6 or BF_4 .

21. A photopolymerization initiator comprising at least two components as claimed in claim 20 wherein the photopolymerization initiator comprises an arylsulfonium salt type compound, and the photo- and thermopolymerization initiator comprises at least one sulfonium salt represented by the general formula (I), (II) or (III).
22. A photopolymerization initiator comprising at least two components as claimed in claim 19 which includes at least one photopolymerization initiator comprising at least two components, and a thermopolymerization initiator comprising at least one of the compounds represented by the following chemical formulae (VIII) and (IX).



23. A resin composition wherein, when the resin composition is exposed to external energy radiation, another kind of energy than the energy from the external energy radiation source is autogenously generated within the resin composition, so that the resin composition is cured by means of the autogenously generated energy, or both the autogenously generated energy and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation, or wherein, when the resin composition is exposed to the external energy radiation, another kind of first energy than the energy from the external energy radiation source is autogenously generated within the resin composition, and the same kind of second energy is successively generated by the generated first energy, so that the resin composition is cured by means of the first and second energies, or both the first and second energies and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation.
24. A resin composition as claimed in claim 23 wherein the resin composition contains a photopolymerization initiator and a photopolymerizable oligomer or photopolymerizable monomer.
25. A resin composition which contains a photopolymerization initiator comprising at least two components including a photopolymerization initiator and a photo- and thermopolymerization initiator for initiating polymerization by means of both light and heat, and wherein, when the resin composition is exposed to external energy radiation, another kind of energy than the energy from the external energy radiation source is autogenously generated within the resin composition, so that the resin composition is cured by means of the autogenously generated energy, or both the autogenously generated energy and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation, or wherein, when the resin composition is exposed to the external energy radiation, another a kind of first energy than the energy from the external energy radiation source is autogenously generated within the resin composition, and the same kind of second energy is successively generated by the generated first energy, so that the resin composition is cured by means of the first and second energies, or both the first and second energies and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation.
26. A resin composition as claimed in claim 25 wherein the photopolymerization initiator comprising at least two components consists essentially or entirely of cationic polymerization initiators, and which further contains a cationic photopolymerizable oligomer or cationic photopolymerizable monomer.
27. A resin composition as claimed in claim 26 wherein the cationic photopolymerizable oligomer or cationic photopolymerizable monomer is a photopolymerizable epoxy oligomer or photopolymerizable epoxy monomer.

28. A resin composition as claimed in claim 27 wherein the photopolymerizable epoxy oligomer or photopolymerizable epoxy monomer is a photopolymerizable alicyclic epoxy oligomer or photopolymerizable alicyclic epoxy monomer.
29. A resin composition as claimed in claim 28 wherein the photopolymerizable alicyclic epoxy monomer is 3,4-epoxycyclohexylmethyl 3,4-epoxycyclohexanecarboxylate.
30. A resin composition as claimed in claim 25 which contains a photopolymerizable oligomer or photopolymerizable monomer and wherein the photopolymerization initiator comprising at least two components is contained in an amount of 0.5 to 6.0 parts by weight per 100 parts by weight of the photopolymerizable oligomer or photopolymerizable monomer, and the weight ratio of the photo- and thermopolymerization initiator to the photopolymerization initiator constituting the photopolymerization initiator comprising at least two components is in the range of 1 to 4.
31. A resin composition as claimed in claim 30 wherein the photopolymerizable oligomer or photopolymerizable monomer is a cationic photopolymerizable oligomer or cationic photopolymerizable monomer.
32. A resin composition as claimed in claim 23 which contains at least one additive selected from energy radiation screening substances, a filler of every kind and an organic component.
33. A resin composition as claimed in claim 23 which additionally contains at least one additive selected from photosensitizers, reactive diluents and photosensitive compounds.
34. A cured product obtained by a resin curing method as claimed in any of claims 1 to 4.
35. A molded article made from a resin composition containing a photopolymerization initiator comprising at least two components as claimed in claim 14.
36. A molded article made from a resin composition as claimed in claim 23.
37. A molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material, other composite material, adhesive, sealer, varnish, paint or coating material, ink or toner which contains a resin composition making it possible to carry out a curing method as claimed in any of claims 1 to 4.
38. A molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material, other composite material, adhesive, sealer, varnish, paint or coating material, ink or toner which contains a photopolymerization initiator comprising at least two components as claimed in claim 14.
39. A molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material, other composite material, adhesive, sealer, varnish, paint or coating material, ink or toner which contains a resin composition as claimed in claim 23.
40. A method of making a molded article of a molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material or other composite material, a cured product of an adhesive, sealer, varnish, paint or coating material, or matter printed with ink or toner, by utilizing a resin curing method as claimed in any of claims 1 to 4.
41. A method of making a molded article of a molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material or other composite material, a cured product of an adhesive, sealer, varnish, paint or coating material, or matter printed with ink or toner, by utilizing a resin composition making it possible to carry out a curing method as claimed in any of claims 1 to 4.
42. A method of making a molded article of a molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material or other composite material, a cured product of an adhesive, sealer, varnish, paint or coating material, or matter printed with ink or toner, by utilizing a resin composition containing a photopolymerization initiator comprising at least two components as claimed in claim 14.
43. A method of making a molded article of a molding material, fiber-reinforced composite material, carbon fiber-reinforced composite material or other composite material, a cured product of an adhesive, sealer, varnish, paint or coating material, or matter printed with ink or toner, by utilizing a resin composition as claimed in claim 23.

44. A method of making a fiber-reinforced composite material or carbon fiber-reinforced composite material as claimed in any of claims 40 to 43 wherein the fiber-reinforced composite material or carbon fiber-reinforced composite material is made by utilizing at least one technique selected from hand lay-up, spray-up, filament winding, tape winding, roll winding, draw molding and continuous roll pressing.

45. A method of making a prepreg which comprises impregnating a reinforcing fiber or a reinforcing fiber cloth material with a resin composition as claimed in claim 23 or 25.

46. A method of making a fiber-reinforced composite material wherein, when a stack of prepregs made by the method of claim 45 is exposed to external energy radiation, another kind of energy than the energy from the external energy radiation source is autogenously generated within the resin composition of the stack, so that the resin composition is cured by means of the autogenously generated energy, or both the autogenously generated energy and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation, or wherein, when the stack is exposed to the external energy radiation, another kind of first energy than the energy from the external energy radiation source is autogenously generated within the resin composition of the stack, and the same kind of second energy is successively generated by the generated first energy, so that the resin composition is cured by means of the first and second energies, or both the first and second energies and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation.

47. A method of making a fiber-reinforced composite material wherein, when a resin composition infiltrated into a three-dimensional textile is exposed to external energy radiation, another kind of energy than the energy from the external energy radiation source is autogenously generated within the resin composition, so that the resin composition is cured by means of the autogenously generated energy, or both the autogenously generated energy and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation, or wherein, when the resin composition is exposed to the external energy radiation, another kind of first energy than the energy from the external energy radiation source is autogenously generated within the resin composition, and the same kind of second energy is successively generated by the generated first energy, so that the resin composition is cured by means of the first and second energies, or both the first and second energies and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation.

48. A method of repairing a fiber-reinforced composite material, building, structure or product wherein, when a resin composition used to fill a part to be repaired of a fiber-reinforced composite material, building, structure or product is exposed to external energy radiation, another kind of energy than the energy from the external energy radiation source is autogenously generated within the resin composition, so that the resin composition is cured by means of the autogenously generated energy, or both the autogenously generated energy and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation, or wherein, when the resin composition is exposed to the external energy radiation, another kind of first energy than the energy from the external energy radiation source is autogenously generated within the resin composition, and the same kind of second energy is successively generated by the generated first energy, so that the resin composition is cured by means of the first and second energies, or both the first and second energies and the energy from the external energy radiation source, whether or not the resin composition contains a substance capable of screening energy radiation.

49. A method of repairing a fiber-reinforced composite material, building, structure or product which comprises attaching a prepreg made by the method of claim 45 to a part to be repaired of a fiber-reinforced composite material, building, structure or product, and curing the prepreg.

50. A method of reinforcing a fiber-reinforced composite material, building, structure or product which comprises attaching a prepreg made by the method of claim 45 to a part to be reinforced of a fiber-reinforced composite material, building, structure or product, and curing the prepreg.

51. A method of reinforcing a fiber-reinforced composite material, building, structure or product which comprises using a reinforcing fiber or reinforcing fiber cloth material impregnated with a resin composition as claimed in claim 23, attaching the reinforcing fiber or reinforcing fiber cloth material to a part to be reinforced of a fiber-reinforced composite material, building, structure or product by spray-up or brushing, and curing the resin composition.

52. A method as claimed in any of claims 40 to 51 wherein the fibrous material is carbon fiber.

53. A method as claimed in any of claims 40, 41 and 43 to 52 wherein there is used a material in which the resin composition contains a photopolymerization initiator comprising at least two components including a photopolymerization initiator and a photo- and thermopolymerization initiator for initiating polymerization by means of both light and heat.

54. A method as claimed in any of claims 40 to 52 wherein the resin composition contains a photopolymerizable oligomer or photopolymerizable monomer and wherein the photopolymerization initiator comprising at least two components is contained in an amount of 0.5 to 6.0 parts by weight per 100 parts by weight of the photopolymerizable oligomer or photopolymerizable monomer, and the weight ratio of the photo- and thermopolymerization initiator to the photopolymerization initiator constituting the photopolymerization initiator comprising at least two components is in the range of 1 to 4.

55. A method as claimed in claim 54 wherein the photopolymerizable oligomer or photopolymerizable monomer is a cationic photopolymerizable oligomer or cationic photopolymerizable monomer.

56. A molded article made by a method as claimed in any of claims 40 to 43.

57. A fiber-reinforced composite material or carbon fiber-reinforced composite material as claimed in any of claims 37 to 39.

58. A molded article made by the method of claim 44.

59. A prepreg made by impregnating a reinforcing fiber or reinforcing fiber cloth material with a resin composition as claimed in any of claims 23 to 33.

60. A fiber-reinforced composite material obtained by curing a prepreg as claimed in claim 59.

61. A fiber-reinforced composite material obtained by impregnating a three-dimensional textile with a resin composition as claimed in any of claims 23 to 33 and curing the resin composition.

62. A repair material for filling a part to be repaired of a fiber-reinforced composite material, building, structure or product which contains a resin composition as claimed in any of claims 23 to 33.

63. A reinforcing material for a fiber-reinforced composite material, building, structure or product which contains a resin composition as claimed in any of claims 23 to 33.

64. A material or molded article as claimed in any of claims 37 to 39 and 56 to 63 wherein the fibrous material is carbon fiber.

65. A material or molded article as claimed in any of claims 37 to 39 and 56 to 64 wherein the resin composition contains a photopolymerization initiator comprising at least two components including a photopolymerization initiator and a photo- and thermopolymerization initiator for initiating polymerization by means of both light and heat.

66. A material or molded article as claimed in any of claims 37 to 39 and 56 to 64 wherein the resin composition contains a photopolymerizable oligomer or photopolymerizable monomer and a photopolymerization initiator comprising at least two components, and wherein the photopolymerization initiator comprising at least two components is contained in an amount of 0.5 to 6.0 parts by weight per 100 parts by weight of the photopolymerizable oligomer or photopolymerizable monomer, and the weight ratio of the photo- and thermopolymerization initiator to the photopolymerization initiator constituting the photopolymerization initiator comprising at least two components is in the range of 1 to 4.

67. A material or molded article as claimed in any of claims 36 to 38 and 56 to 64 wherein the resin composition contains a photopolymerizable oligomer or photopolymerizable monomer and a photopolymerization initiator comprising at least two components, and wherein the photopolymerization initiator comprising at least two components is contained in an amount of 0.5 to 6.0 parts by weight per 100 parts by weight of the photopolymerizable oligomer or photopolymerizable monomer, and the weight ratio of the photo- and thermopolymerization initiator to the photopolymerization initiator constituting the photopolymerization initiator comprising at least two components is in the range of 1 to 4.

lymerization initiator constituting the photopolymerization initiator comprising at least two components is in the range of 1 to 4.

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FIG. 1

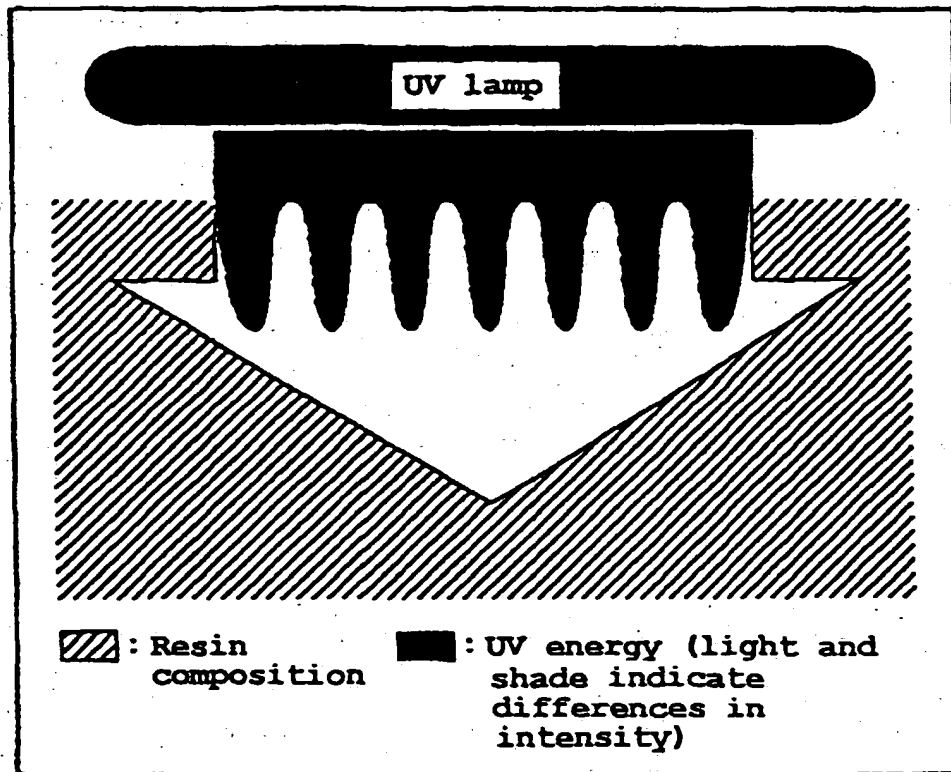


FIG. 2

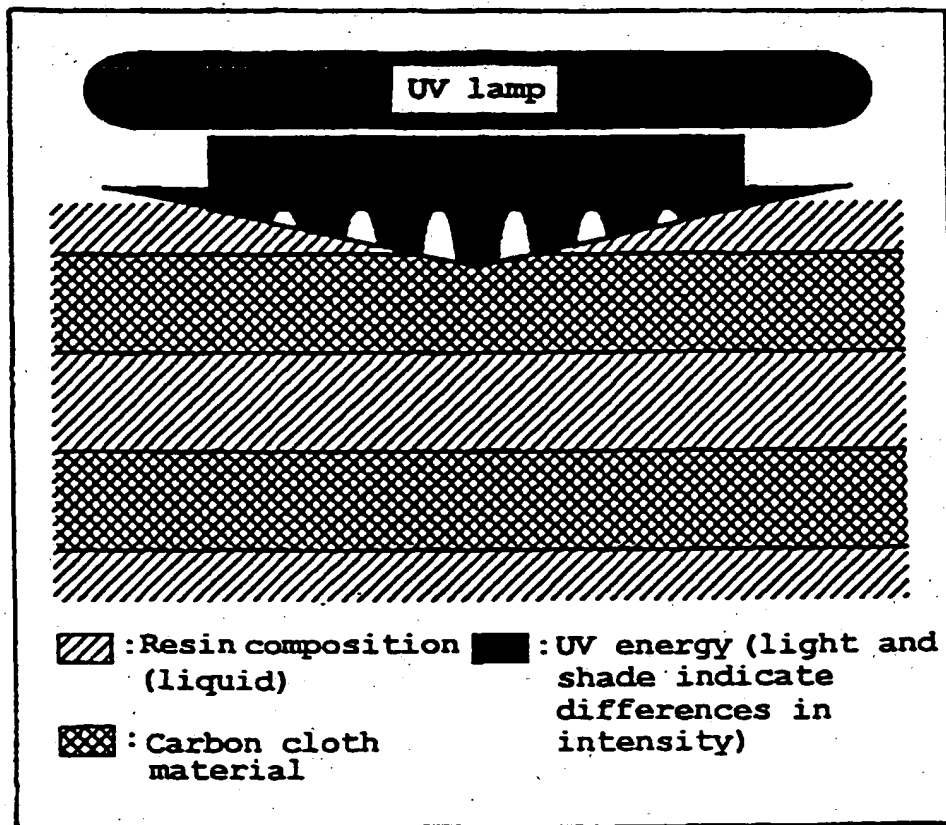


FIG. 3

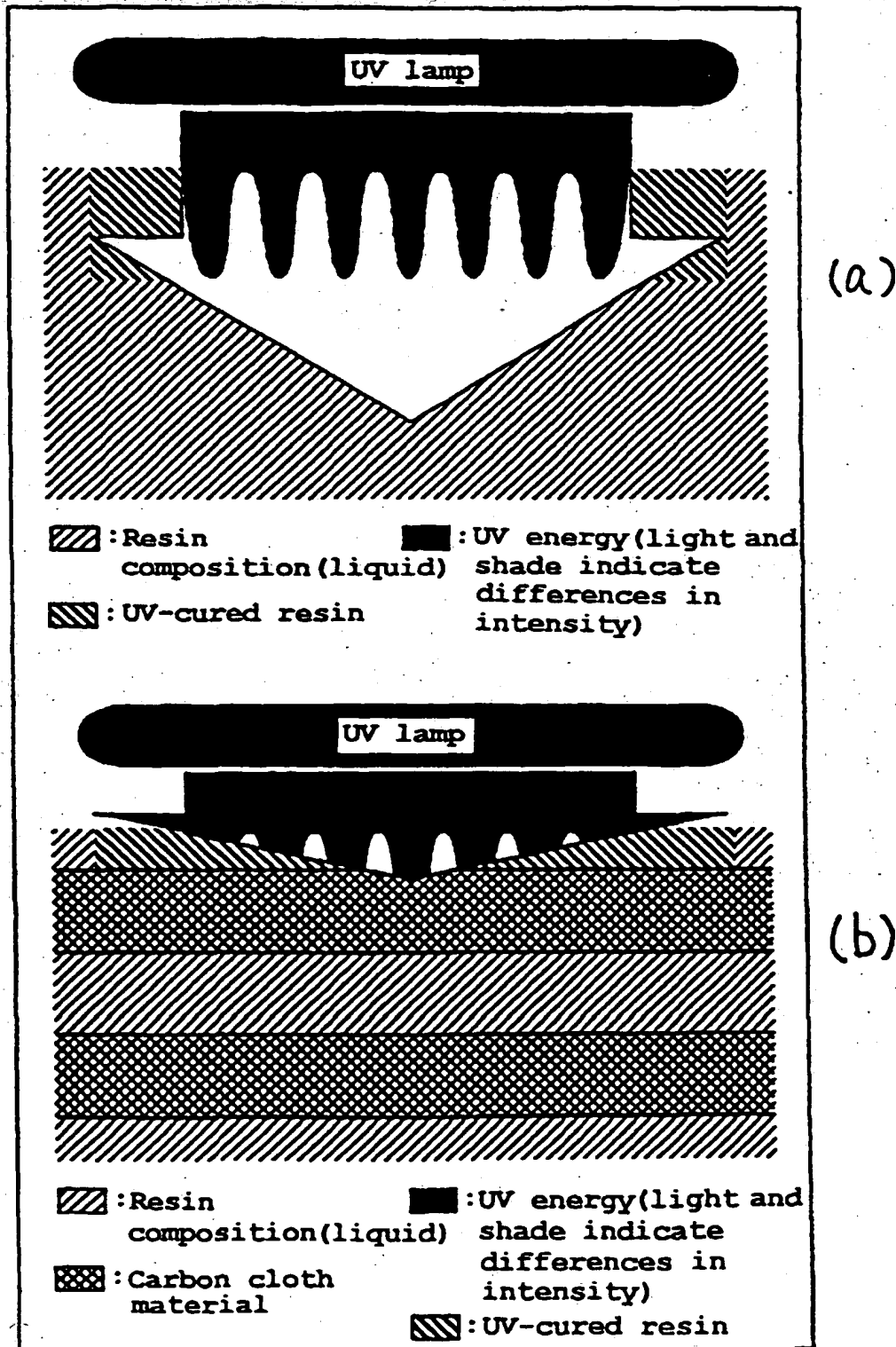


FIG. 4

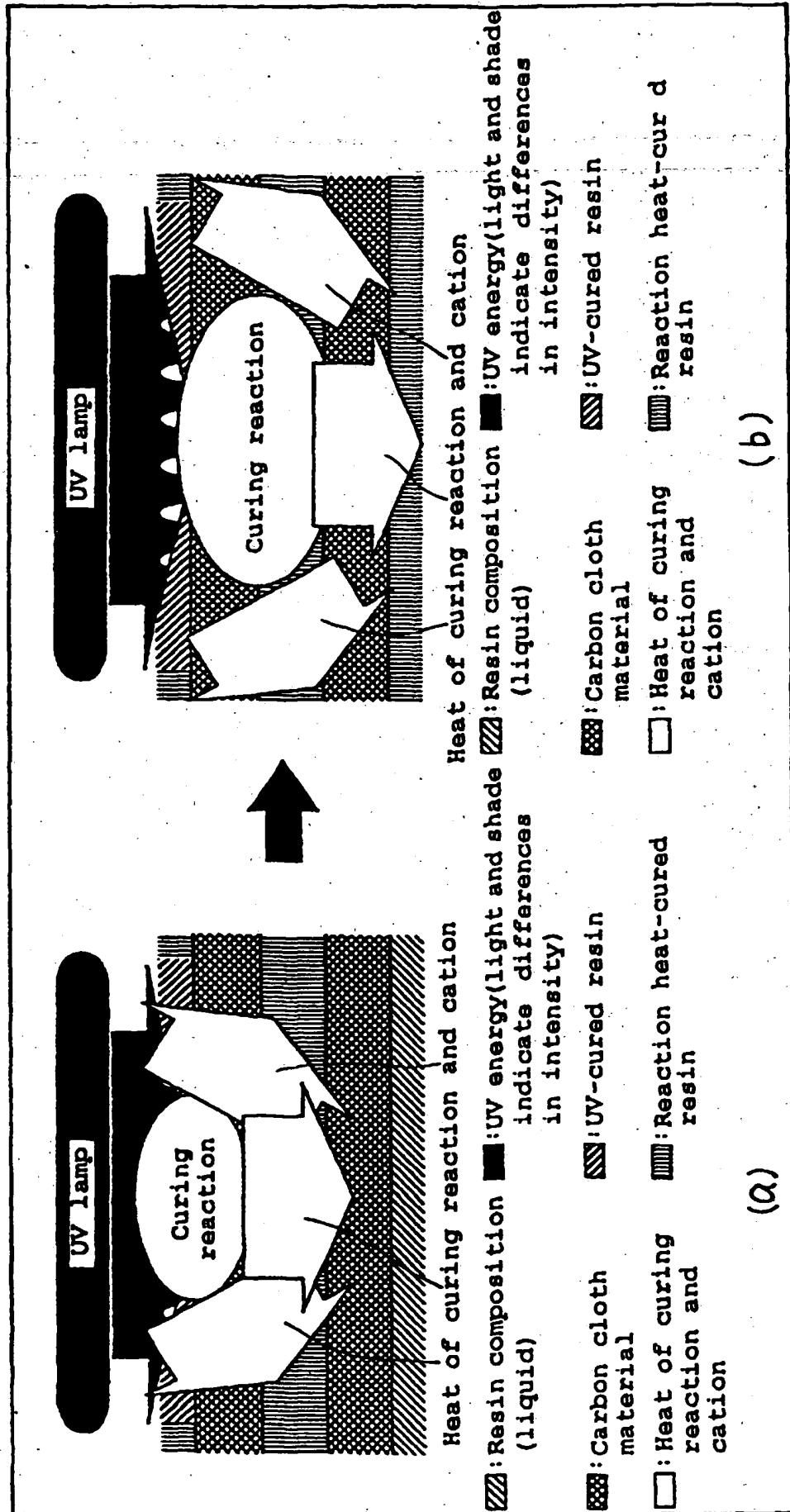
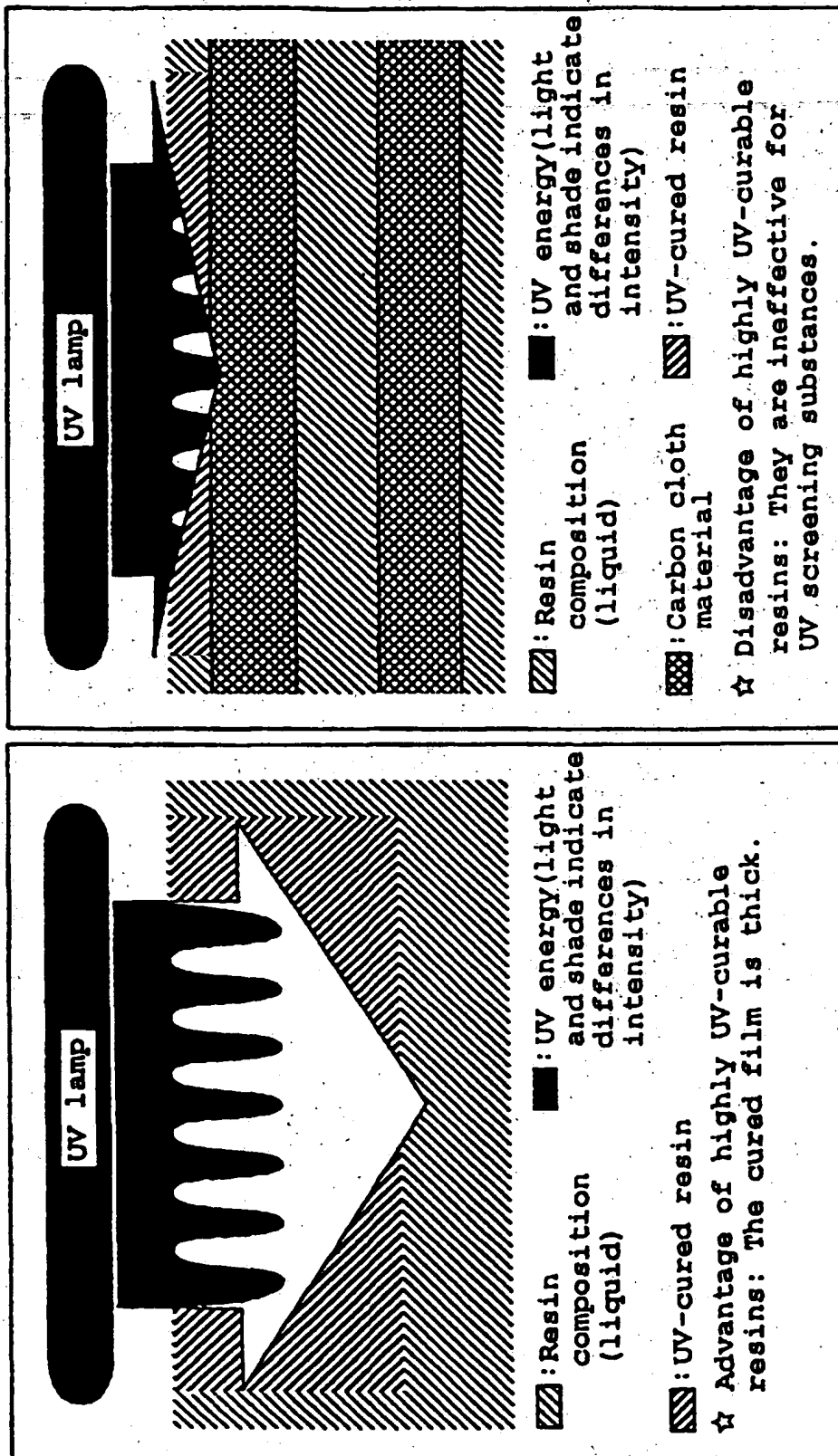


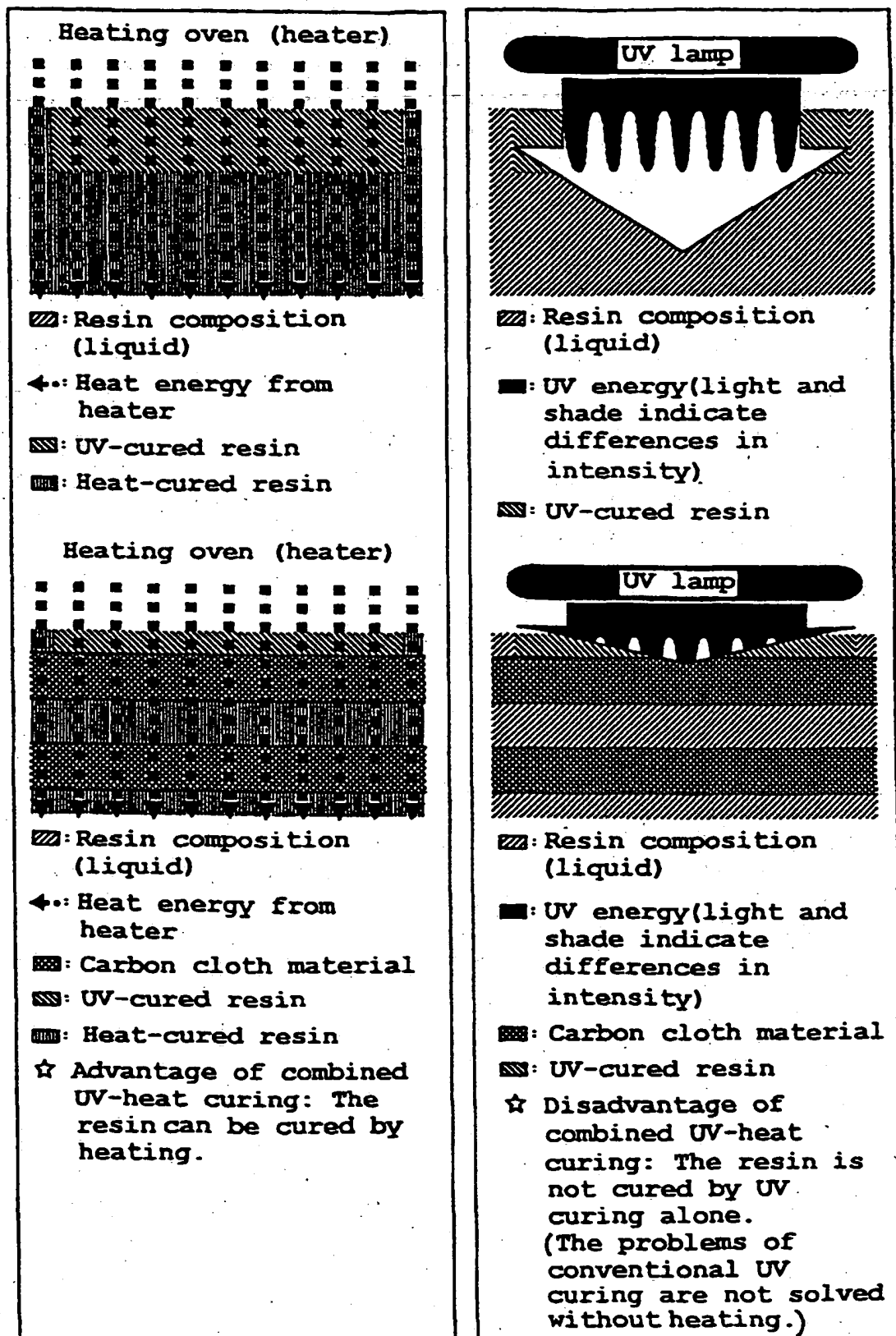
FIG. 5



(a)

(b)

FIG. 6



(a)

(b)

FIG. 7

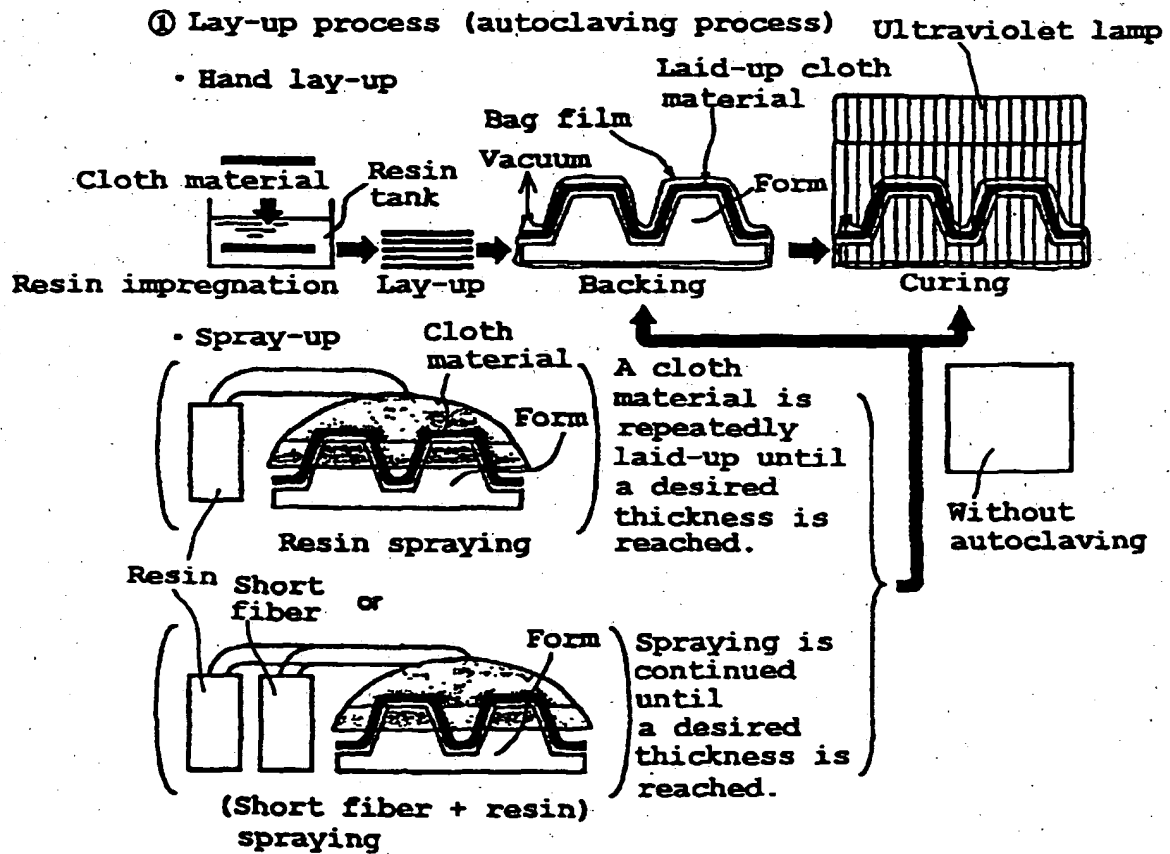
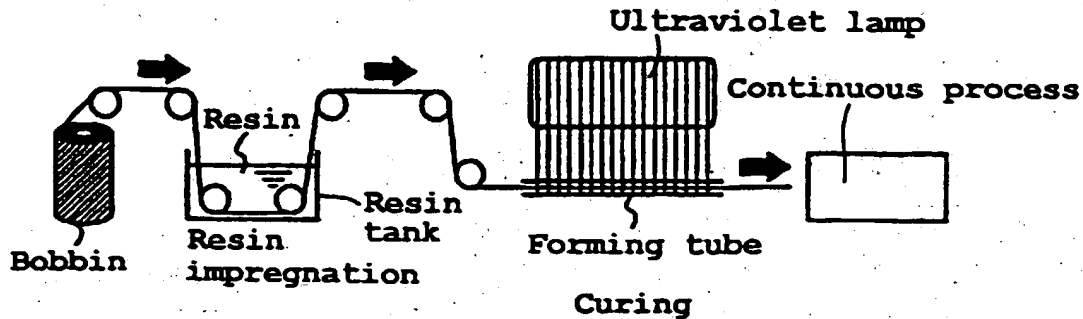
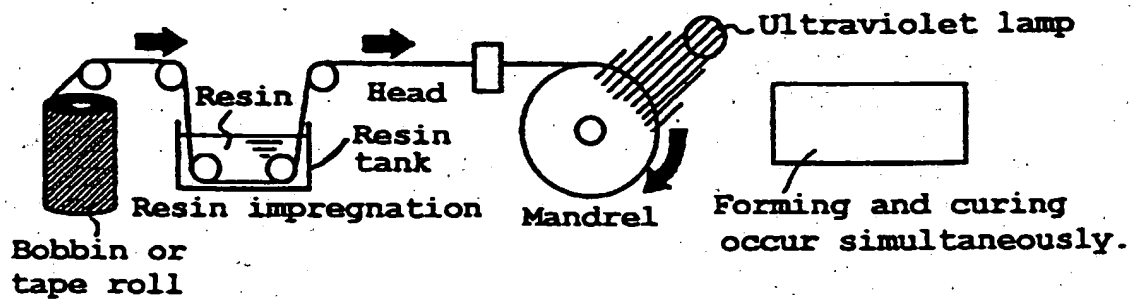


FIG. 8

② Drawing process



③ Filament/tape/roll winding process



④ Continuous roll pressing process

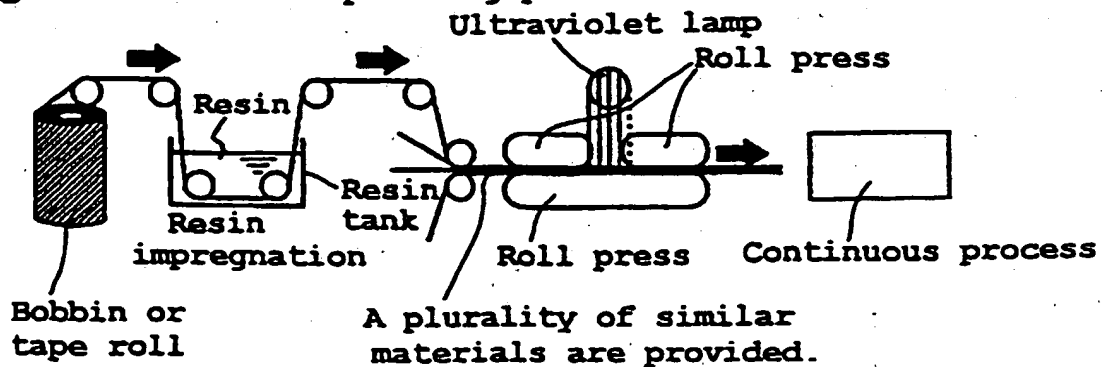


FIG.9

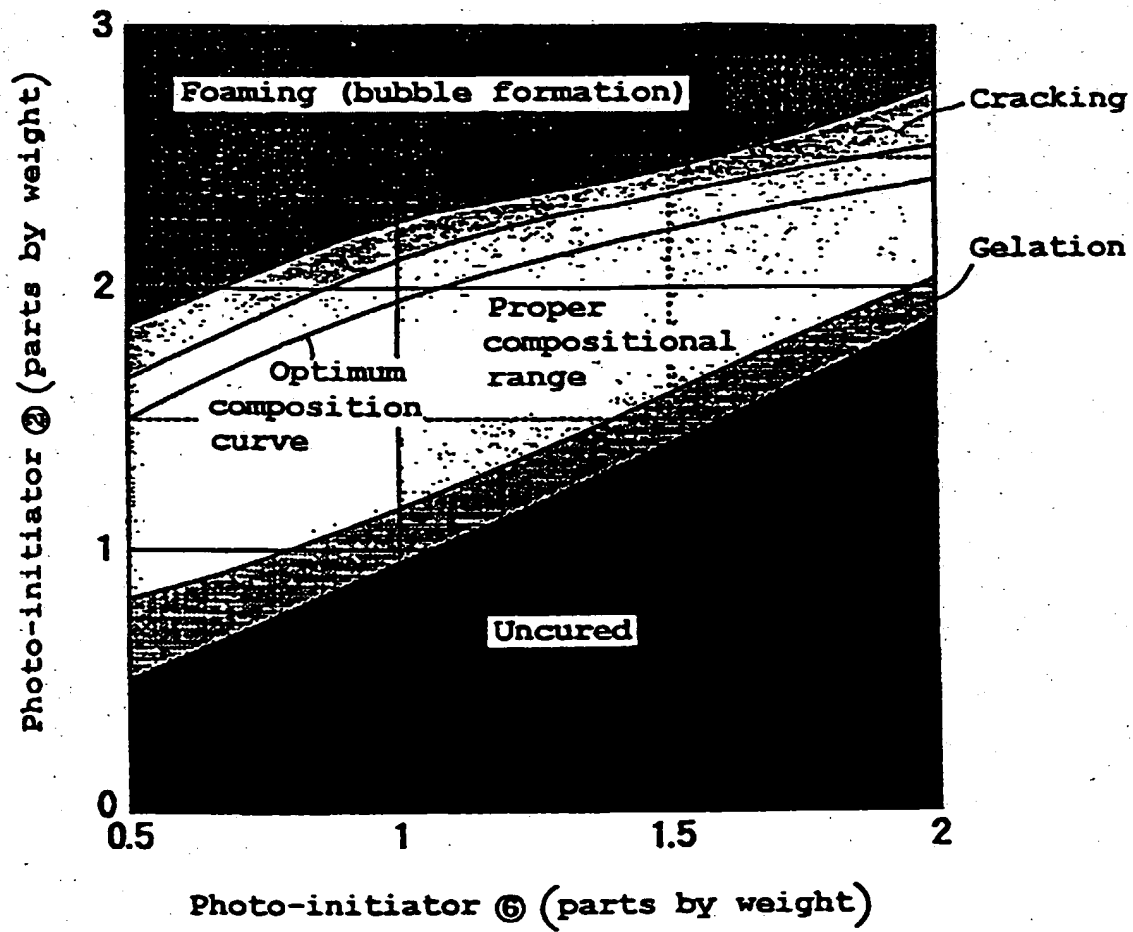
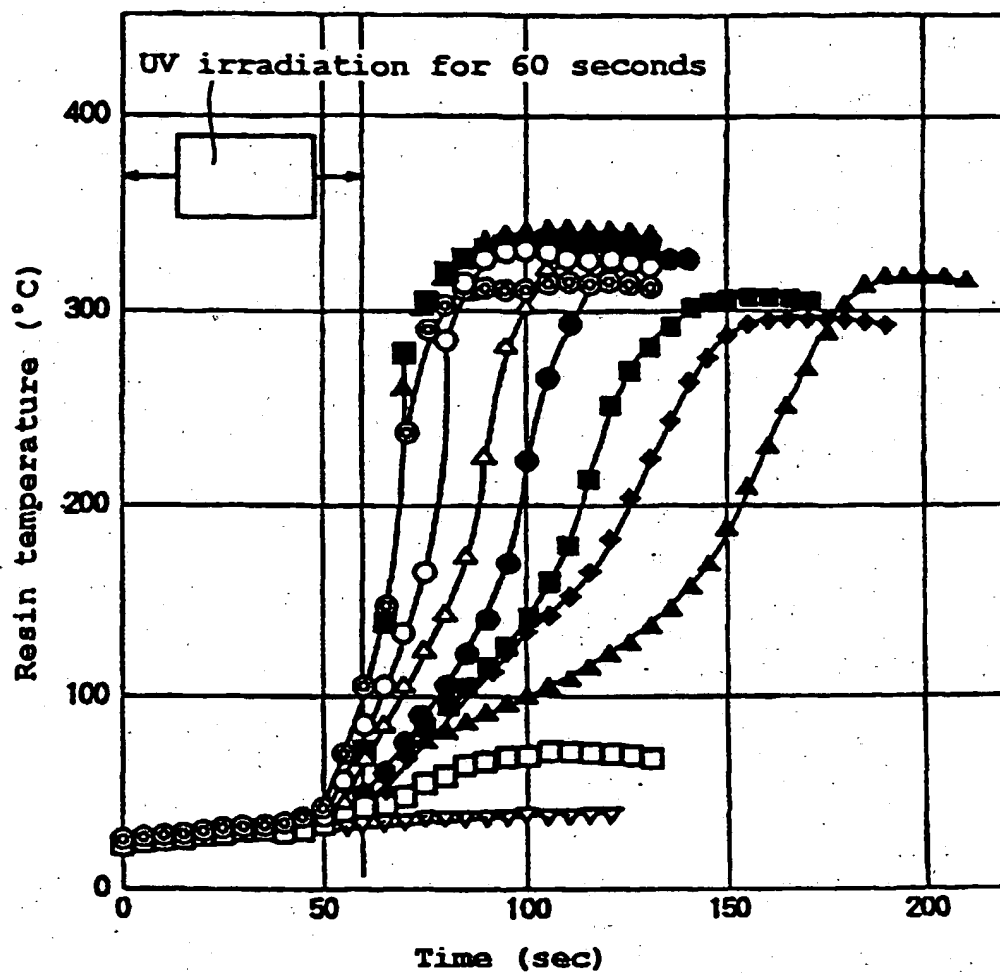


FIG.10



Cured state	
	Cured (rapid)
	Cured (slow)
	Foamed
	Uncured

	Composition ①
	Composition ②
	Composition ③
	Composition ④
	Composition ⑤
	Composition ⑥
	Composition ⑦
	Composition ⑧
	Composition ⑨
	Composition ⑩
	Composition ⑪

FIG. 11

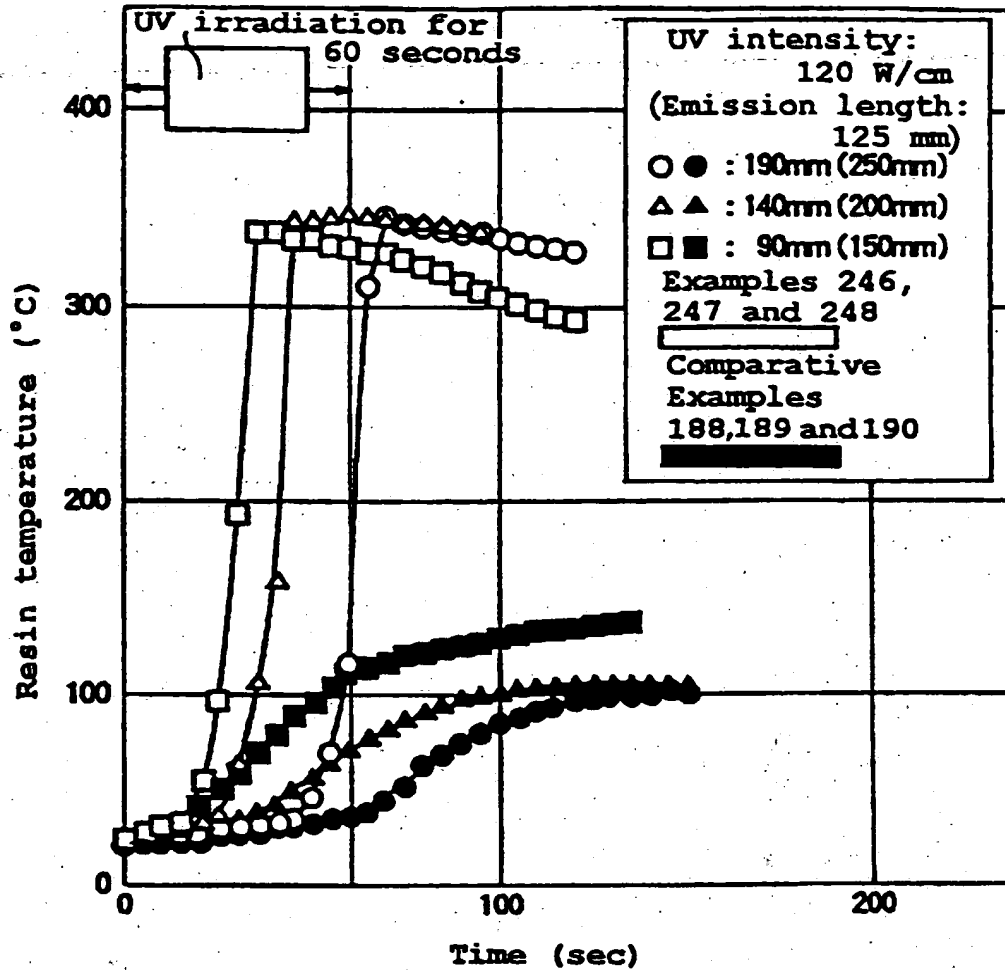
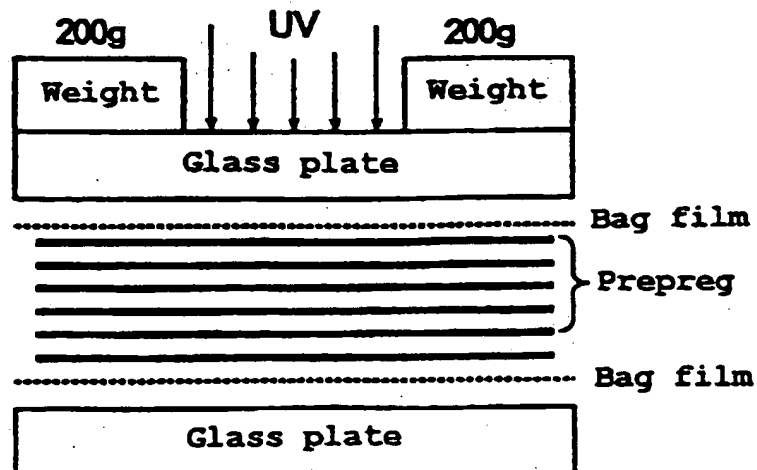


FIG. 12



INTERNATIONAL SEARCH REPORT

International application No.

PCT/JP98/04660

A. CLASSIFICATION OF SUBJECT MATTER Int.Cl ⁶ C08G59/40, C09D163/00, C09D4/00, C08J5/24 According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) Int.Cl ⁶ C08G59/40-66, C09D163/00-10, C09D4/00-06, C08J5/24 Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	JP, 61-12725, A (Toshiba Corp.), 21 January, 1986 (21. 01. 86), Claims (Family: none)	1-67
A	JP, 7-179572, A (Siemens AG.), 18 July, 1995 (18. 07. 95), Claims & EP, 504569, B1 & US, 5242715, A	1-67
A	JP, 10-24496, A (Mitsubishi Heavy Industries, Ltd.), 27 January, 1998 (27. 01. 98), Claims (Family: none)	1-67
<input type="checkbox"/> Further documents are listed in the continuation of Box C. <input type="checkbox"/> See patent family annex.		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier document but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed		"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family
Date of the actual completion of the international search 25 January, 1999 (25. 01. 99)		Date of mailing of the international search report 2 February, 1999 (02. 02. 99)
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